



PRECITOOLS
PRESS BRAKE TOOLS
TW SYSTEM LINE

Version 1.000 2023 WEB ENG



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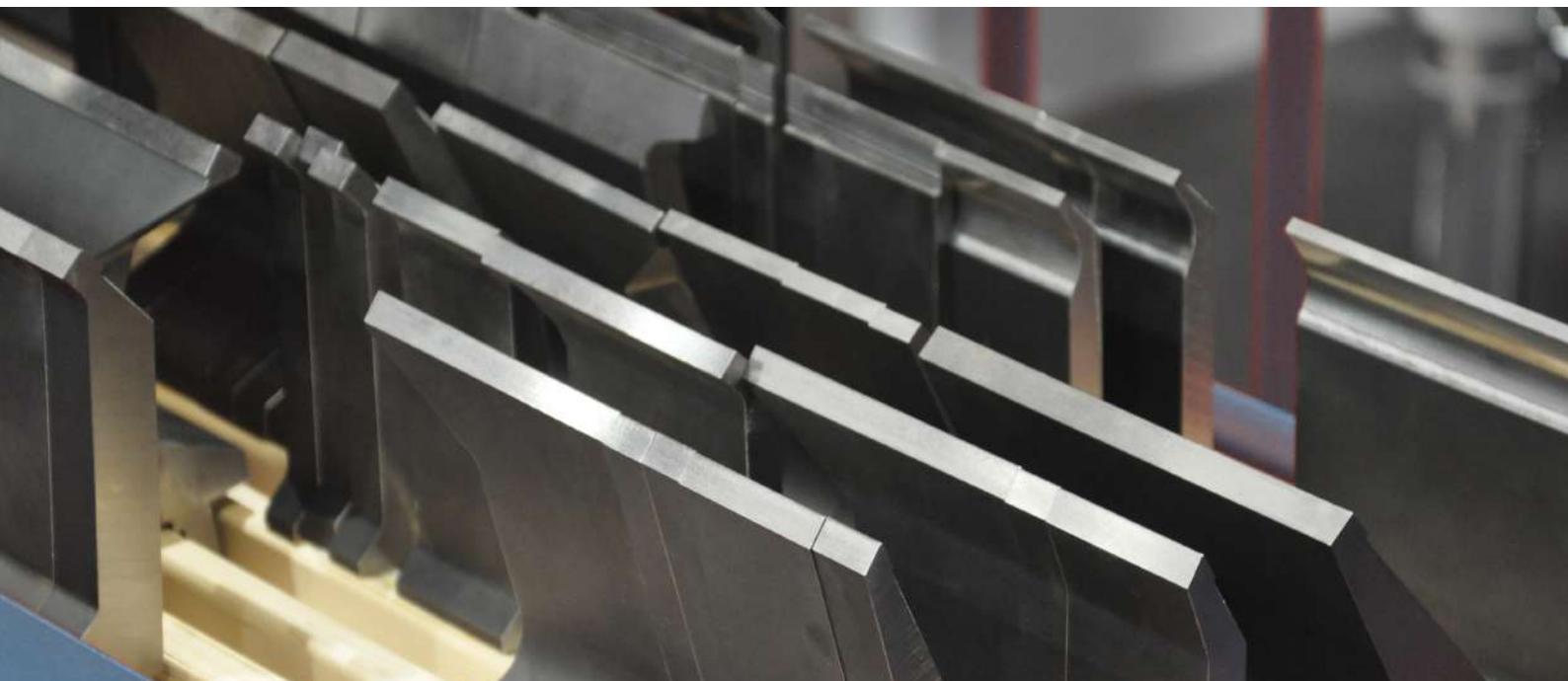
About us

PRECITOOLS is a professional industrial supplier of press brake tools (bending tooling) for various press brake models and manufacturers. We are able to offer any standard or special types of bending tools (punches and dies, hemming sets, stamps, punch holders, die holders, adapters, die inserts, radius tooling, etc.) for main press brake clamping systems, including the accessories. We can supply a great selection of standard tool geometry shapes or make any special tools under the request of the customer including the length of 6000-8000 mm in one piece, together with specialized technical customer support for any press brake bending application.

Together with standard positions, we have good skills and experience in the technology of bending which allows us to offer our customers the most advanced and effective solutions even in standard, special, or mixed configurations.

Every time we are looking for friendly and professional cooperation relations with the mission goal of the customer and technical satisfaction. Today PRECITOOLS operates completely worldwide with direct sales, authorized professional dealers, and partners in European Union and outside markets.

Availability on stock for most common positions allows offering from our side the possibilities of 24h/ 48h/ 72h deliveries which grant our customers the receipt of tooling in the shortest times. Moreover, we are trying to study all the projects with the possibility to offer standard tools with a short delivery time and more effective prices. We are able to make delivery to any place in European Union for a quick time and reasonable prices thanks to the partnership with leading Italian and international transport companies.





Production



We can confirm that our press brake tools are manufactured with the use of professional CNC machine tools with high-quality standards, Italian raw materials, and the highest precision and tolerance to be obtained for the long use of our products. "Made in Italy" similar to the best quality and today Italian press brake tools are one of the most powerful products accepted in production in industries all over the world.

The big variety of standard pieces equal to competitors' products allows offering from us different solutions and geometry even with standard tools to perform the quality of different bends even with complicated shape configurations. The reasonable and competitive price ranges including the seasonal discount offers allow our customers to choose Italian-origin tools even against even other brands and countries.

Our press brake tools are passed through the induction hardening process to have the maximum protection and hardness on the working areas where the tool has contact with the part during the bending process. The Standard declared hardness is 55-60 HRC. Depth is 3-4 mm. We use high-quality local materials which fit the best metallurgical standards and conditions.

During the study of projects, there are a lot of reasons why standard press brake tools are not enough to make the part. Sometimes it is enough to modify the radius, sometimes we need to offer tools with special lengths and sometimes it is necessary to prepare new geometry of tooling. Any project came from the idea but finally should be supplied as the complete working tool to realize the bend.

We are ready to provide any solutions according to our experience with a reasonable price and verification of the possibility to bend with the software simulation. Any drawing could be verified and modified by the customer choosing the material.

Besides the punches, we can provide special Multi-V bending dies and individual adapters for your press brake. We have various solutions for special bending tools for special forming, punching, flattening, deep bending, etc.



TW System line

We offer a rich selection of standard press brake tools for Precitoools TW System. TW is the main tooling system to use with press brakes Trumpf, Safan, modern Prima Power, etc., and is used on a lot of press brakes as the optional tool system. The advantages are long-life tools with high-resistance materials, big heights to prevent collisions, and the possibility of frontal loading and mirror repositioning. The last years could be optionally ordered for Amada press brakes (AMTS type).

Main manufacturers supported:

Press brake tools for machines: Amada (AMTS type), Bystronic-Hammerle, Durma, EHT, Finn-Power, Jordi, Gzelis, LVD, Trumpf, Prima Power, RICO PRCN, Safan-Darley, STR, Ursviken, etc. Press brakes equipped with other tooling systems could work with TW punches and dies through clamping adapters.

Interchangeability:

All main punches and dies of the TW line "Professional standard" 100% correspond to the main geometry of the system and could be used even together with the punches or dies of other manufacturers.

TW line dies are interchangeable with the BST line (for Beyeler-Bystronic -type press brakes) and have 100% equal tang configuration. Some punches and dies are equal to original production programs with full correspondence.

Tooling from other systems could be used through the special adapter.

Production program:

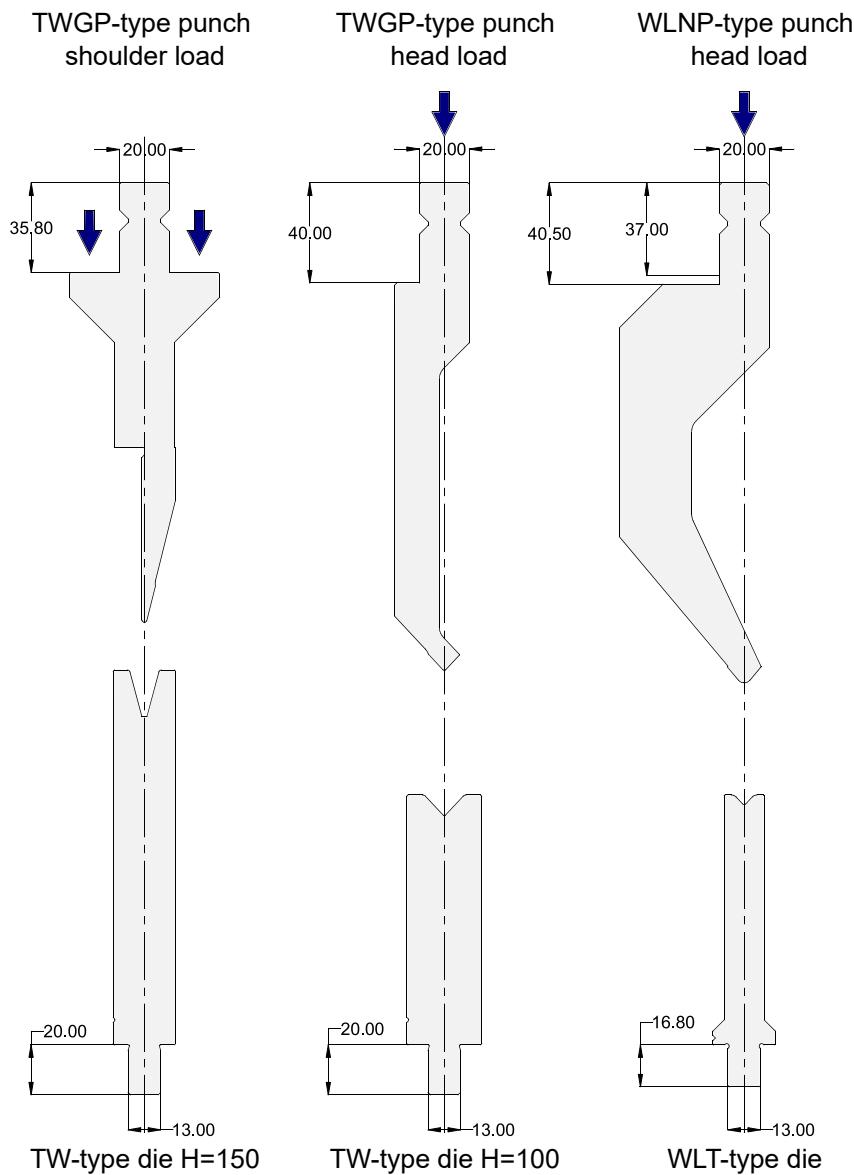
- ❖ 86° punches TWGP- and WLNP- types (straight and gooseneck types)
- ❖ 80° punches TWGP- and WLNP- types (straight and gooseneck types)
- ❖ 60° punches TWGP- and WLNP- types (straight and gooseneck types)
- ❖ 28° punches TWGP- and WLNP- types (straight and acute types)
- ❖ 26° punches TWGP- types (acute types)
- ❖ Holders with radius inserts till R50
- ❖ Standard 1V H=100 dies 86° / 84° / 80° / 60° / 30° till V120 (TW Professional)
- ❖ Standard 1V H=100 dies 86° / 80° / 30° till V100 (TW Economy)
- ❖ Standard 1V H=100 dies 30° with R3 (TW Professional)
- ❖ Standard 1V H=150 dies 86° / 30° (TW Economy)
- ❖ Standard 1V H=100 dies 86° / 80° / 30° till V24 (WLT Professional)
- ❖ Standard 1V H=55 dies 86° / 30° till V20 (WLT Professional)
- ❖ Standard 1V H=55 dies 88° / 30° till V60 (BST line)
- ❖ Hemming flattening sets 24° / 28°
- ❖ Holders with inserts for Z-bends
- ❖ Adapters

Lengths and sectioned sets according to the description of the code

Non-standard geometries, production according to the codes and geometry of other manufacturers, and special solutions are available under the request with the complete customization



Tooling system overview



Buttons / safety clicks

Pieces with a weight of less than 12,5 kg (normally all small height punches and small sections up to 100 mm) are equipped by buttons as default and included in the price. Quantity of buttons - 1 for punches up to 100 mm; 2 for punches bigger than 100 mm in length. Buttons are removable elements and could be easily replaced by the operator if any problem or spring wear. The length of the button according to the geometry of the punch, could be not replaceable with the punch with other geometry and width.

Optionally any punch could be ordered with pins only for lateral loading and standard for all pieces heavier than 12,5 kg.

Reduced weight punches

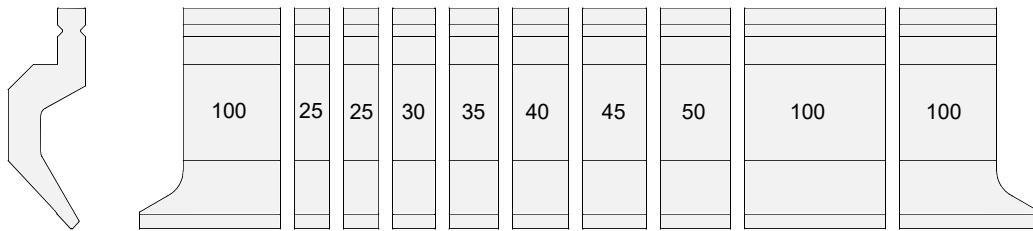
Additional milling to reduce the weight of the punch is possible under the request of customization. Reduction of weight is done to have the possibility to install the buttons even for heavier punches and also assist the operator to prevent handling of heavy pieces during the bending tool changes. This option is available only for thin materials bending because affects the complete tool available tonnage.



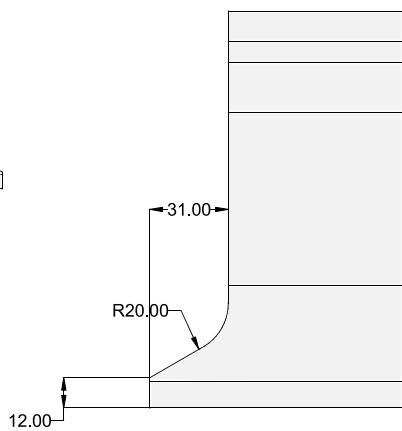


Segmentation sets overview:

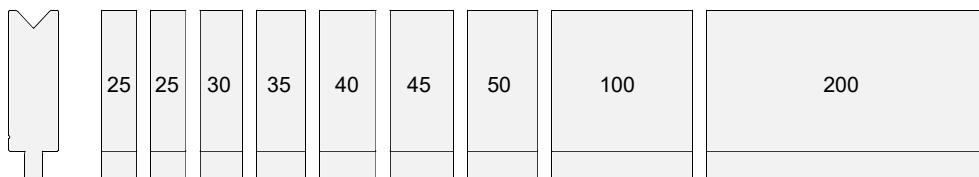
TWGP-type punches segmentation L=550 mm total:



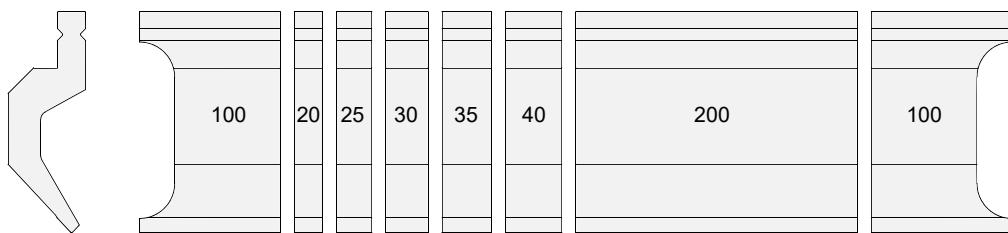
TWGP-type horn:



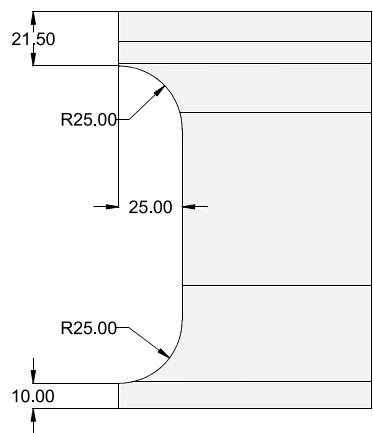
TW Professional / TW Economy -type dies segmentation L=550 mm total:



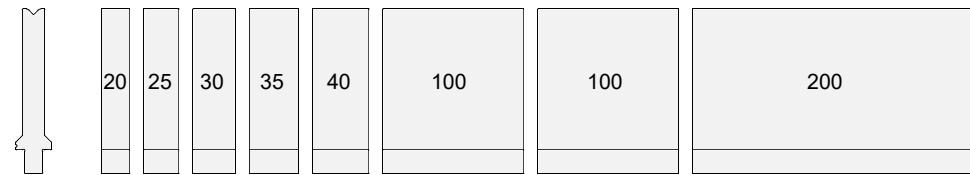
WLNP-type punches segmentation L=550 mm total:



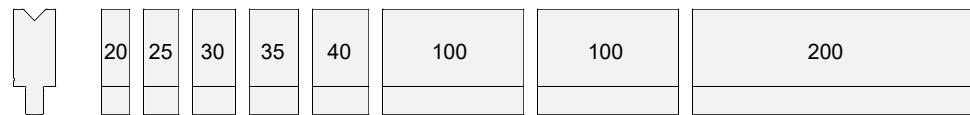
WLNP-type horn:



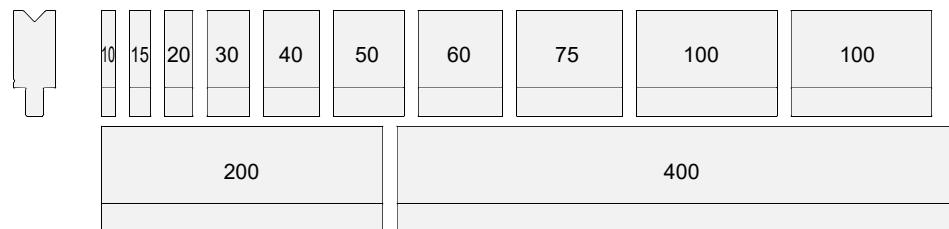
WLT Professional -type dies segmentation L=550 mm total:



BST -type dies segmentation L=550 mm total:



BST -type dies segmentation L=1100 mm total:

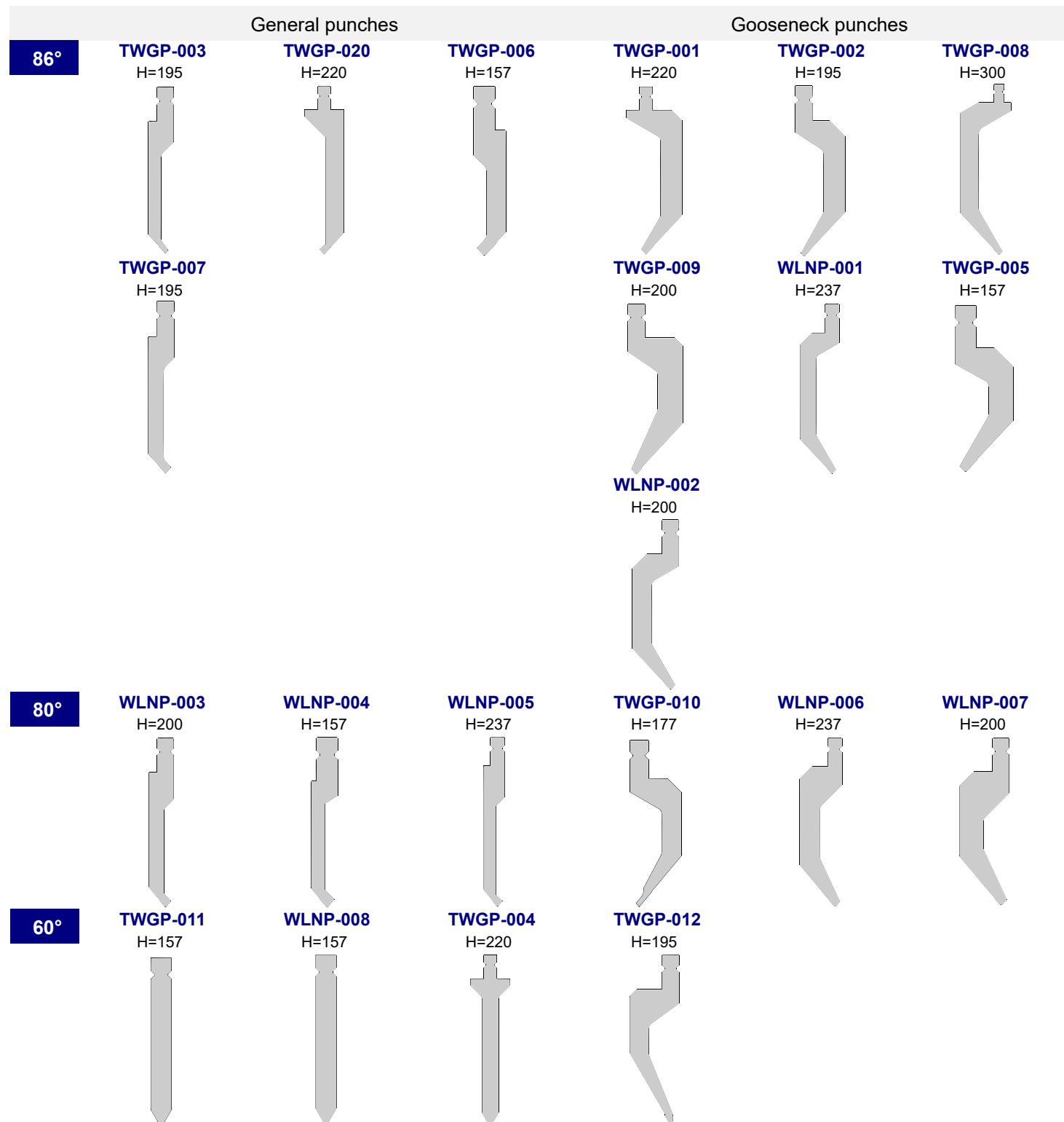


Special cutting available

For additional requests we able to perform the cutting to your specifications or milling of horns to your geometry
The cutting is performed of standard pieces as desired length + rest piece
Buttons (safety clicks) as standard for sectioned punches sets

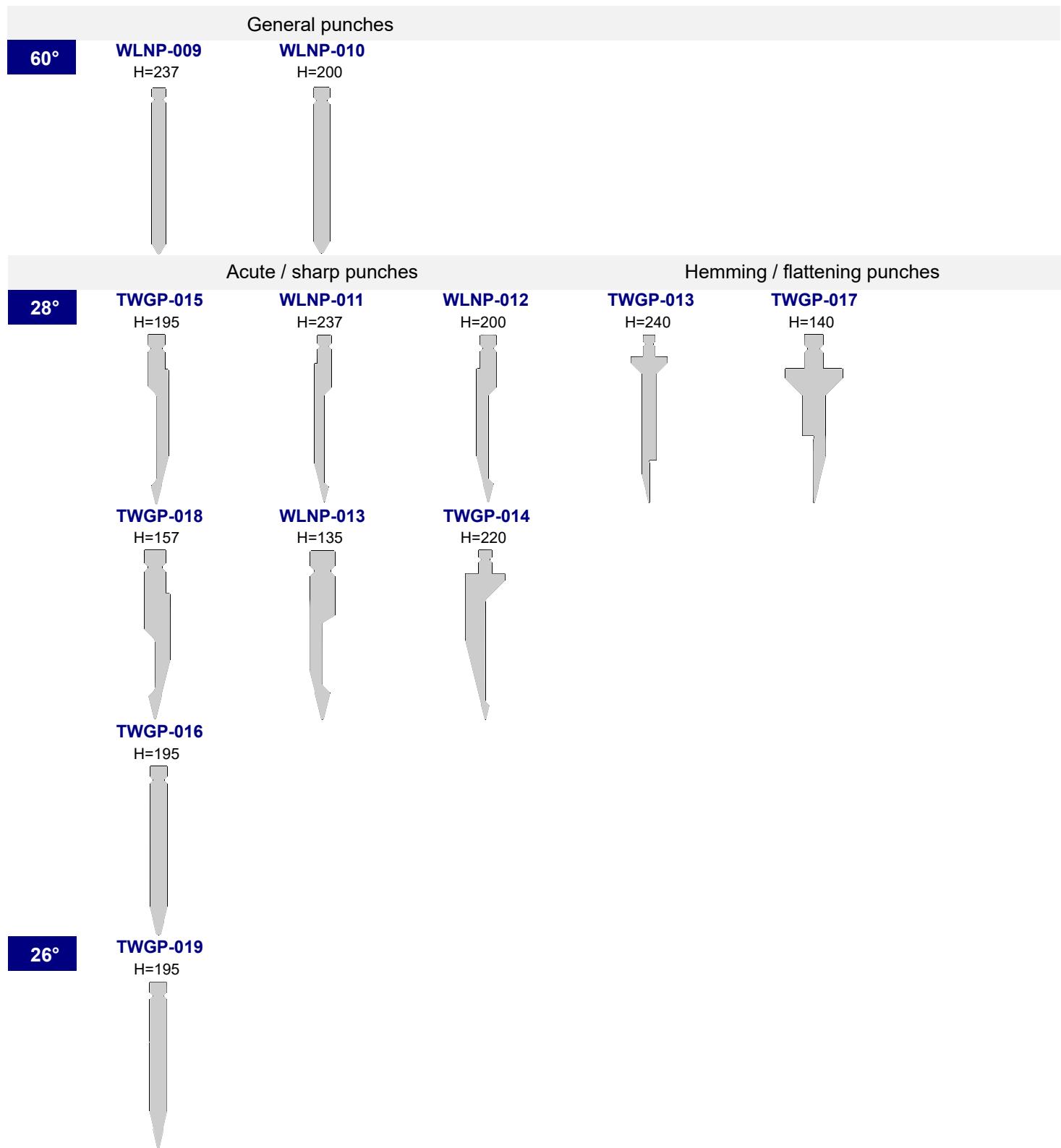


Punches types overview





Punches types overview





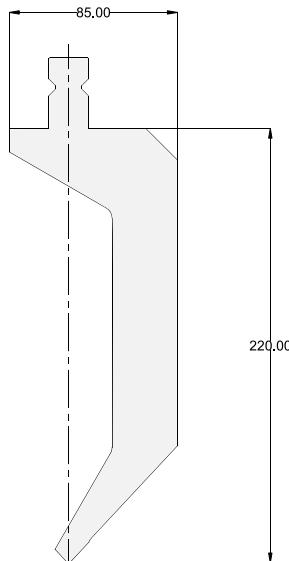
Punch TWGP-001

Angle	Radius	Height	Tonnage
86°	1,0	220	80 t/m

Material 42CrMo4
Buttons available up to 200 mm pieces
Approx. weight 67,2 kg/m

Shoulders loading

Length of pieces available:
25 - 30 - 35 - 40 - 45 - 50 mm
100 hornL - 100 hornR - 100 - 200 - 300 - 500 mm
550 mm standard sectioned set

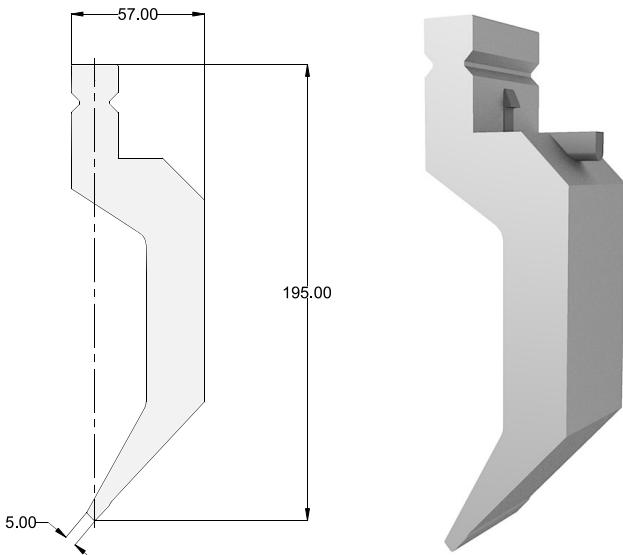


Punch TWGP-002

Angle	Radius	Height	Tonnage
86°	0,8	195	40 t/m

Material 42CrMo4
Buttons available up to 300 mm pieces
Approx. weight 36,8 kg/m

Length of pieces available:
25 - 30 - 35 - 40 - 45 - 50 mm
100 hornL - 100 hornR - 100 - 200 - 300 - 500 mm
550 mm standard sectioned set

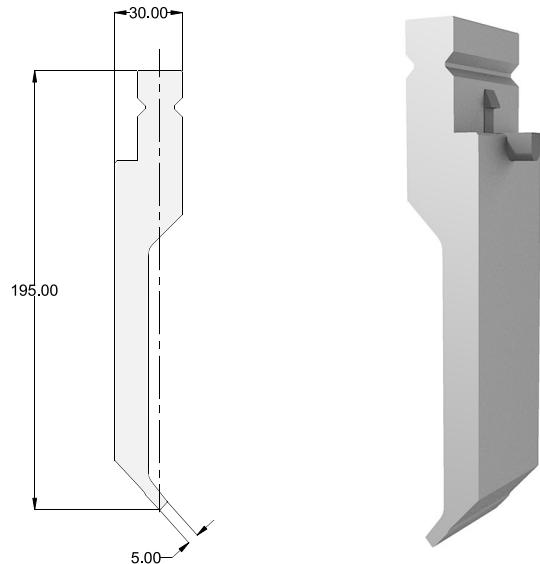


Punch TWGP-003

Angle	Radius	Height	Tonnage
86°	0,6	195	30 t/m

Material 42CrMo4
Buttons available up to 500 mm pieces
Approx. weight 26,6 kg/m

Length of pieces available:
25 - 30 - 35 - 40 - 45 - 50 mm
100 hornL - 100 hornR - 100 - 200 - 300 - 500 mm
550 mm standard sectioned set





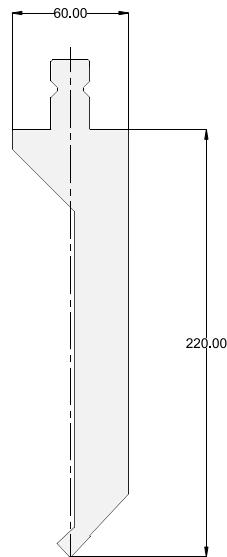
Punch TWGP-020

Angle	Radius	Height	Tonnage
86°	1,0	220	80 t/m

Material 42CrMo4
Buttons available up to 200 mm pieces
Approx. weight 57,0 kg/m

Shoulders loading

Length of pieces available:
100 - 200 - 300 - 500 mm
550 mm standard sectioned set

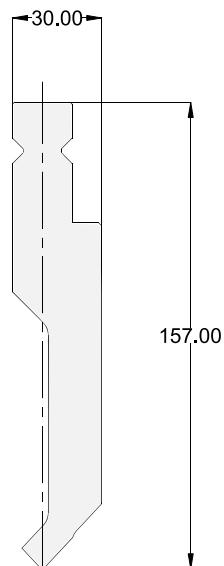


Punch TWGP-006

Angle	Radius	Height	Tonnage
86°	1,0	157	100 t/m

Material 42CrMo4
Buttons available up to 500 mm pieces
Approx. weight 24,2 kg/m

Length of pieces available:
25 - 30 - 35 - 40 - 45 - 50 mm
100 hornL - 100 hornR - 100 - 200 - 300 - 500 mm
550 mm standard sectioned set

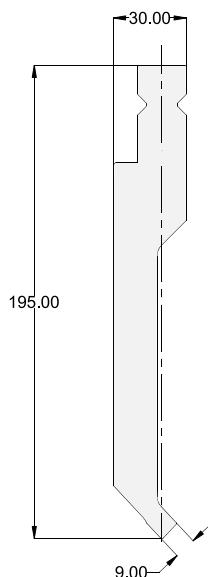


Punch TWGP-007

Angle	Radius	Height	Tonnage
86°	0,8	195	100 t/m

Material 42CrMo4
Buttons available up to 300 mm pieces
Approx. weight 30,0 kg/m

Length of pieces available:
25 - 30 - 35 - 40 - 45 - 50 mm
100 hornL - 100 hornR - 100 - 200 - 300 - 500 mm
550 mm standard sectioned set





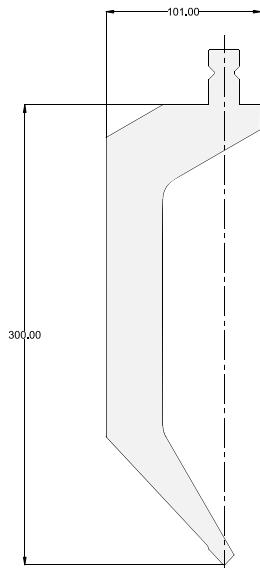
Punch TWGP-008

Angle	Radius	Height	Tonnage
86°	1,0	300	80 t/m

Material 42CrMo4
Buttons available up to 100 mm pieces
Approx. weight 98,0 kg/m

Shoulders loading

Length of pieces available:
25 - 30 - 35 - 40 - 45 - 50 mm
100 hornL - 100 hornR - 100 - 200 mm
550 mm standard sectioned set

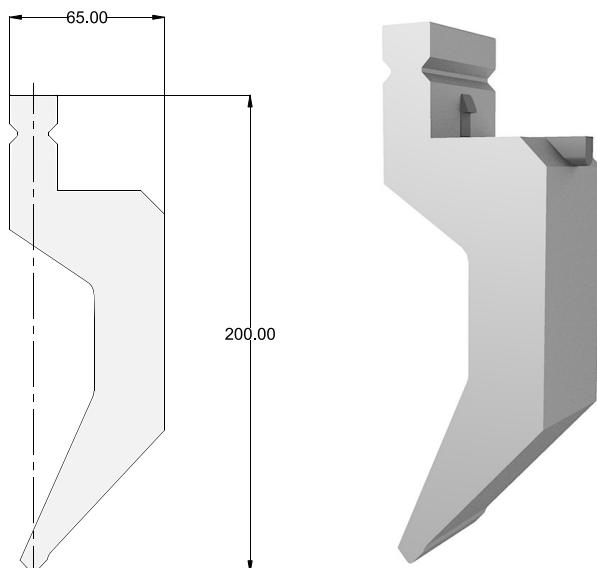


Punch TWGP-009

Angle	Radius	Height	Tonnage
86°	1,5	200	100 t/m

Material 42CrMo4
Buttons available up to 200 mm pieces
Approx. weight 47,2 kg/m

Length of pieces available:
25 - 30 - 35 - 40 - 45 - 50 mm
100 hornL - 100 hornR - 100 - 200 - 300 - 500 mm
550 mm standard sectioned set

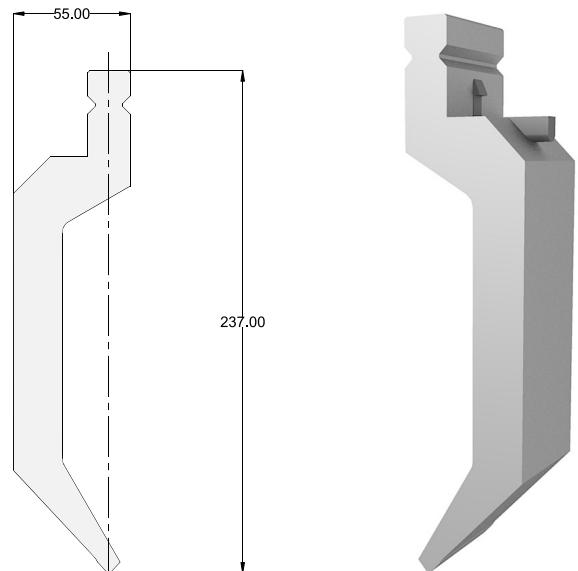


Punch WLNP-001

Angle	Radius	Height	Tonnage
86°	1,0	237	65 t/m

Material 42CrMo4
Buttons available up to 200 mm pieces
Approx. weight 43,5 kg/m

Length of pieces available:
100 - 200 - 515 mm
550 mm WLNP-type sectioned set

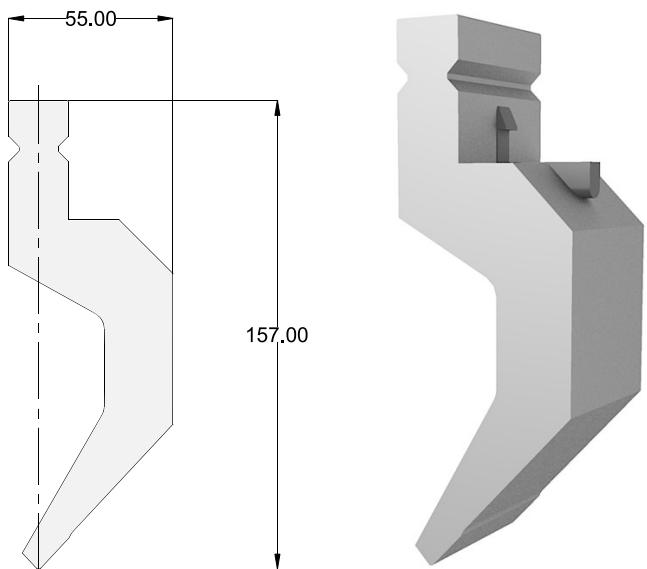




Punch TWGP-005

Angle	Radius	Height	Tonnage
86°	1,0	157	70 t/m

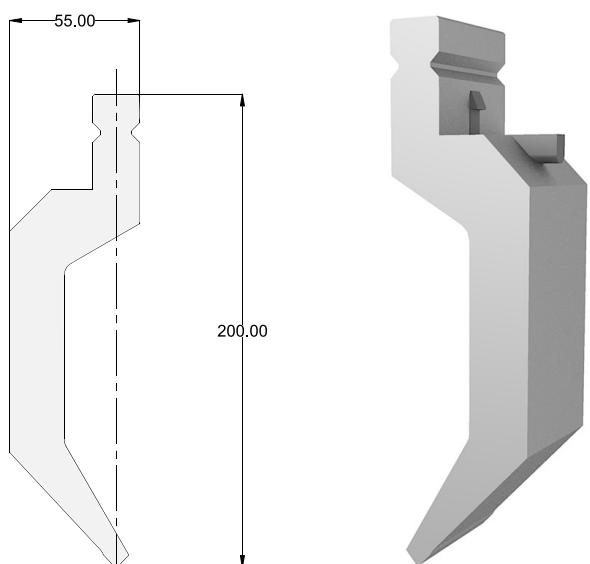
Material 42CrMo4
Buttons available up to 300 mm pieces
Approx. weight 29,2 kg/m



Punch WLNP-002

Angle	Radius	Height	Tonnage
86°	1,0	200	65 t/m

Material 42CrMo4
Buttons available up to 200 mm pieces
Approx. weight 38,2 kg/m



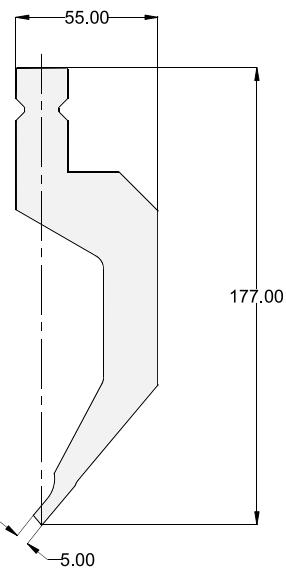


Punch TWGP-010

Angle	Radius	Height	Tonnage
80°	0,5	177	40 t/m

Material 42CrMo4
Buttons available up to 300 mm pieces
Approx. weight 30,8 kg/m

Length of pieces available:
25 - 30 - 35 - 40 - 45 - 50 mm
100 hornL - 100 hornR - 100 - 200 - 300 - 500 mm
550 mm standard sectioned set

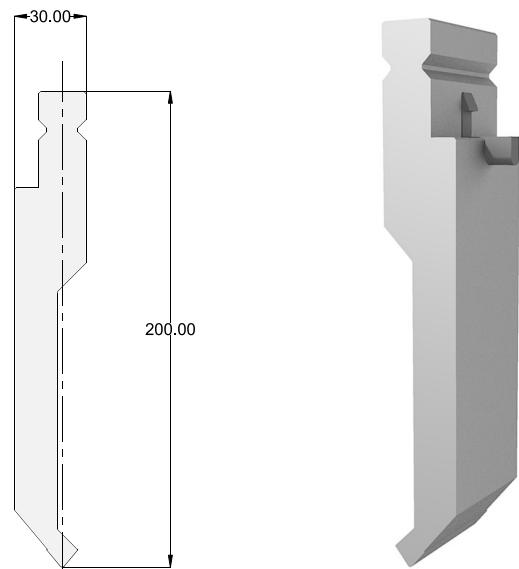


Punch WLNP-003

Angle	Radius	Height	Tonnage
80°	1,0	200	80 t/m

Material 42CrMo4
Buttons available up to 200 mm pieces
Approx. weight 31,0 kg/m

Length of pieces available:
100 - 200 - 515 mm
550 mm WLNP-type sectioned set

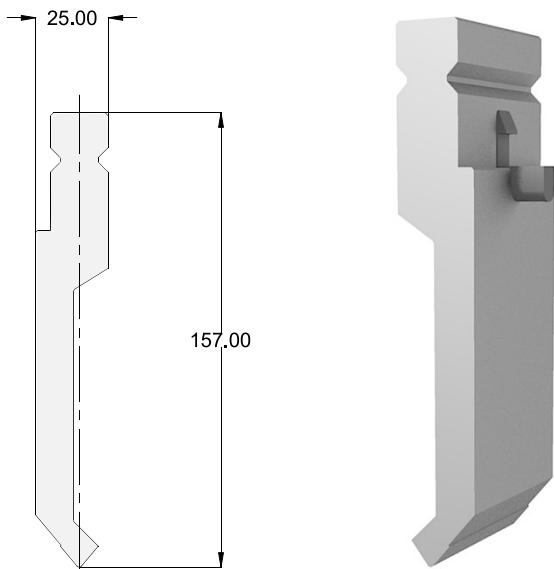


Punch WLNP-004

Angle	Radius	Height	Tonnage
80°	1,0	157	100 t/m

Material 42CrMo4
Buttons available up to 515 mm pieces
Approx. weight 19,0 kg/m

Length of pieces available:
100 - 200 - 515 mm
550 mm WLNP-type sectioned set

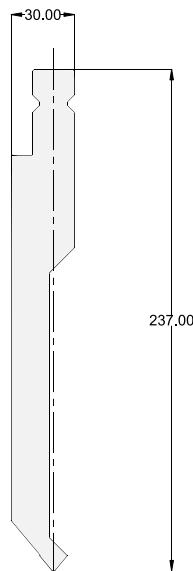




Punch WLNP-005

Angle	Radius	Height	Tonnage
80°	1,0	237	80 t/m

Material 42CrMo4
Buttons available up to 200 mm pieces
Approx. weight 37,5 kg/m



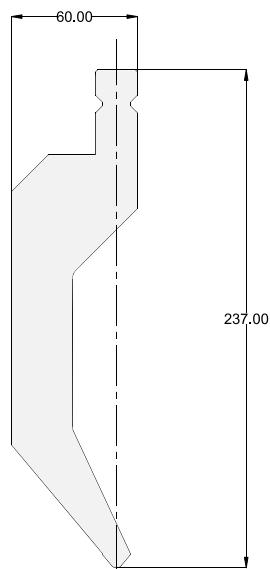
Length of pieces available:

100 - 200 - 515 mm
550 mm WLNP-type sectioned set

Punch WLNP-006

Angle	Radius	Height	Tonnage
80°	3,0	237	100 t/m

Material 42CrMo4
Buttons available up to 200 mm pieces
Approx. weight 56,0 kg/m



Length of pieces available:

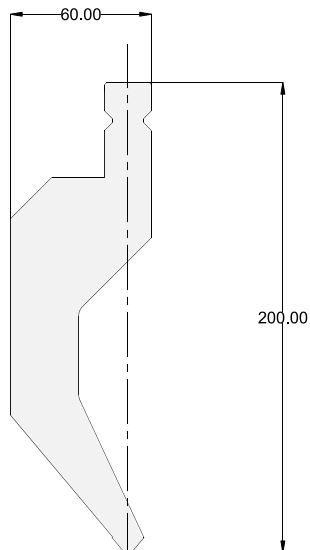
100 - 200 - 515 mm
550 mm WLNP-type sectioned set

Punch WLNP-007

Angle	Radius	Height	Tonnage
80°	3,0	200	100 t/m

Material 42CrMo4
Buttons available up to 200 mm pieces
Approx. weight 48,0 kg/m

Length of pieces available:
100 - 200 - 515 mm
550 mm WLNP-type sectioned set

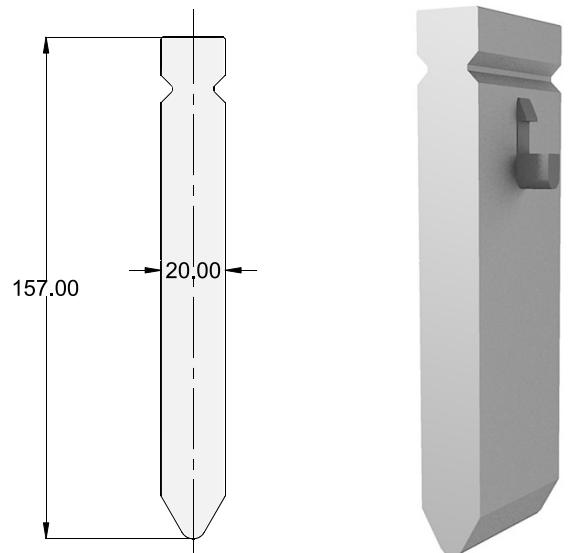




Punch TWGP-011

Angle	Radius	Height	Tonnage
60°	4,0	157	180 t/m

Material 42CrMo4
Buttons available up to 500 mm pieces
Approx. weight 23,6 kg/m



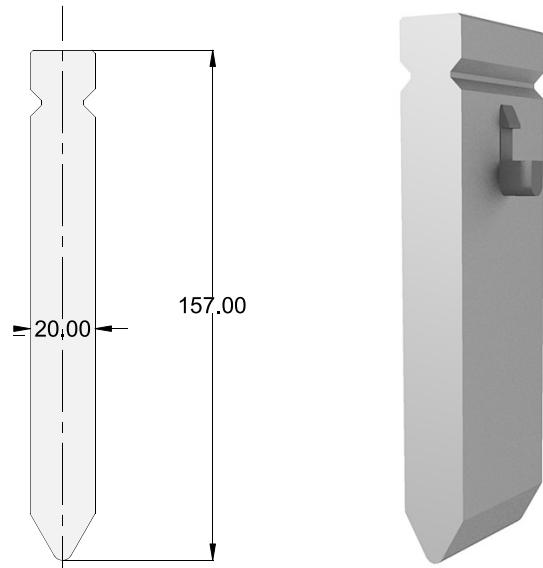
Length of pieces available:

25 - 30 - 35 - 40 - 45 - 50 mm
100 hornL - 100 hornR - 100 - 200 - 300 - 500 mm
550 mm standard sectioned set

Punch WLNP-008

Angle	Radius	Height	Tonnage
60°	3,0	157	160 t/m

Material 42CrMo4
Buttons available up to 500 mm pieces
Approx. weight 24,0 kg/m



Length of pieces available:

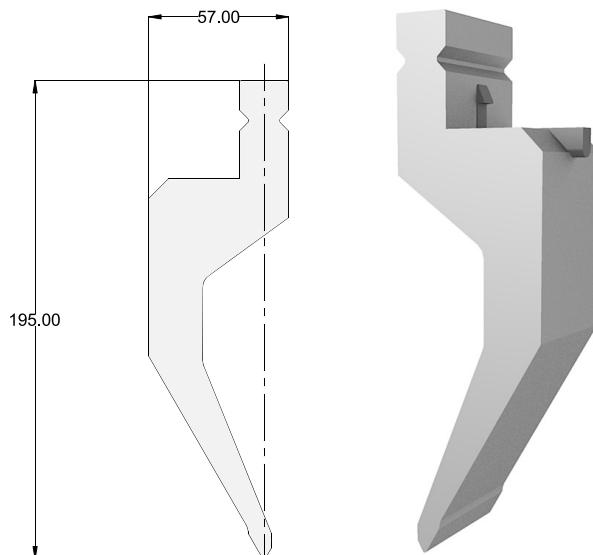
100 - 200 - 515 mm
550 mm WLNP-type sectioned set

Punch TWGP-012

Angle	Radius	Height	Tonnage
60°	0,8	195	40 t/m

Material 42CrMo4
Buttons available up to 300 mm pieces
Approx. weight 34,8 kg/m

Length of pieces available:
25 - 30 - 35 - 40 - 45 - 50 mm
100 hornL - 100 hornR - 100 - 200 - 300 - 500 mm
550 mm standard sectioned set





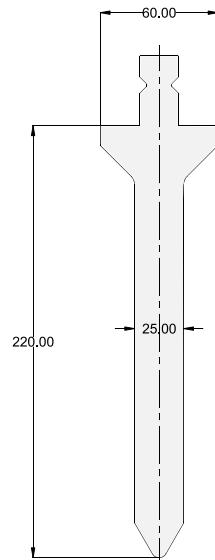
Punch TWGP-004

Angle	Radius	Height	Tonnage
60°	4,0	220	250 t/m

Material 42CrMo4
Buttons available up to 200 mm pieces
Approx. weight 52,1 kg/m

Shoulders loading

Length of pieces available:
25 - 30 - 35 - 40 - 45 - 50 mm
100 hornL - 100 hornR - 100 - 200 - 300 - 500 mm
550 mm standard sectioned set

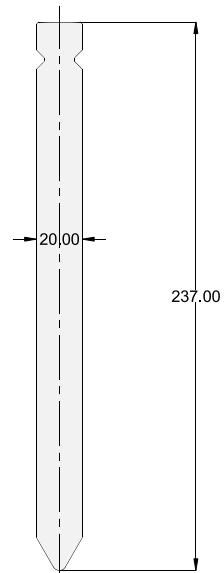


Punch WLNP-009

Angle	Radius	Height	Tonnage
60°	3,0	237	160 t/m

Material 42CrMo4
Buttons available up to 200 mm pieces
Approx. weight 37,0 kg/m

Length of pieces available:
100 - 200 - 515 mm
550 mm WLNP-type sectioned set

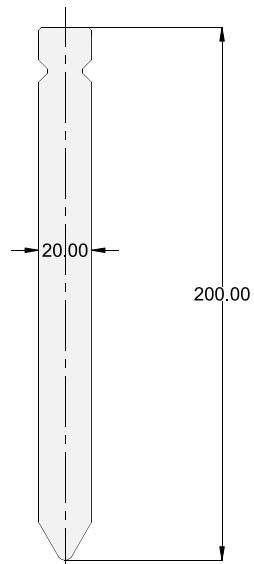


Punch WLNP-010

Angle	Radius	Height	Tonnage
60°	3,0	200	160 t/m

Material 42CrMo4
Buttons available up to 200 mm pieces
Approx. weight 31,8 kg/m

Length of pieces available:
100 - 200 - 515 mm
550 mm WLNP-type sectioned set

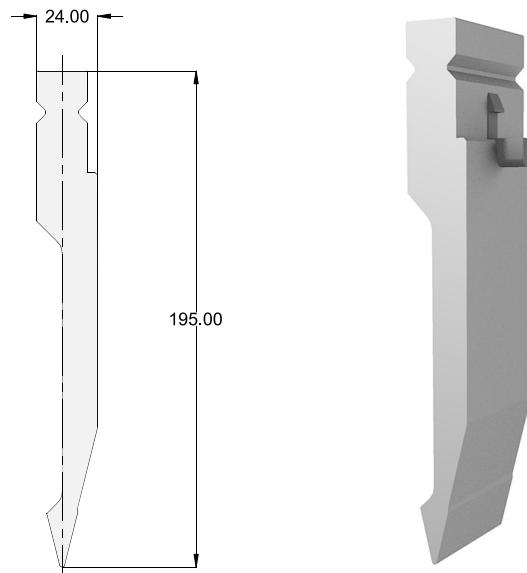




Punch TWGP-015

Angle	Radius	Height	Tonnage
28°	1,0	195	80 t/m

Material 42CrMo4
Buttons available up to 500 mm pieces
Approx. weight 23,0 kg/m



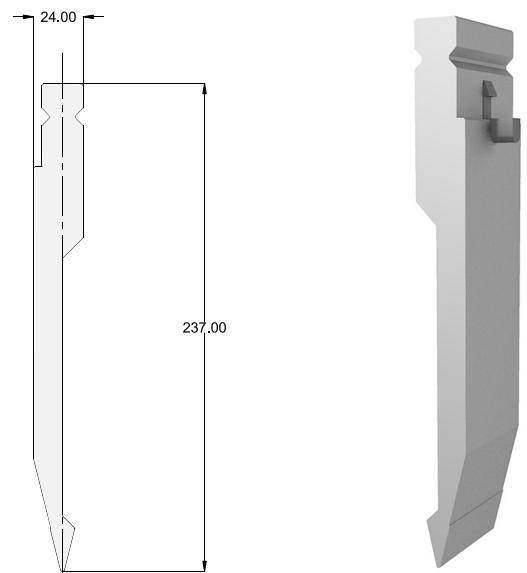
Length of pieces available:

25 - 30 - 35 - 40 - 45 - 50 mm
100 hornL - 100 hornR - 100 - 200 - 300 - 500 mm
550 mm standard sectioned set

Punch WLNP-011

Angle	Radius	Height	Tonnage
28°	1,0	237	80 t/m

Material 42CrMo4
Buttons available up to 200 mm pieces
Approx. weight 28,5 kg/m



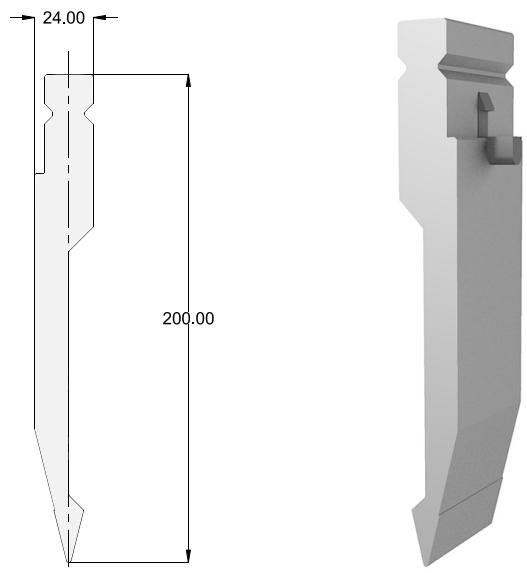
Length of pieces available:

100 - 200 - 515 mm
550 mm WLNP-type sectioned set

Punch WLNP-012

Angle	Radius	Height	Tonnage
28°	1,0	200	80 t/m

Material 42CrMo4
Buttons available up to 515 mm pieces
Approx. weight 24,0 kg/m



Length of pieces available:

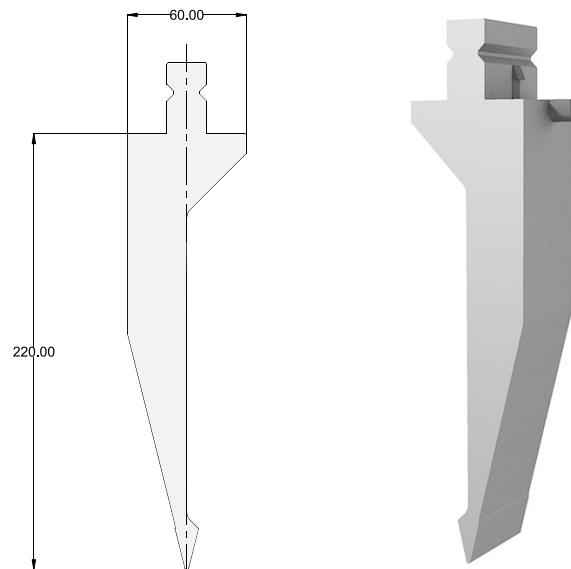
100 - 200 - 515 mm
550 mm WLNP-type sectioned set



Punch TWGP-014

Angle	Radius	Height	Tonnage
28°	1,0	220	80 t/m

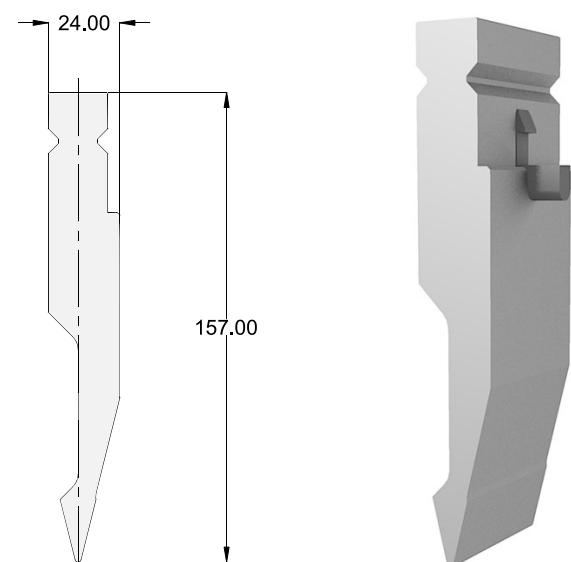
Material 42CrMo4
Buttons available up to 200 mm pieces
Approx. weight 50,0 kg/m



Punch TWGP-018

Angle	Radius	Height	Tonnage
28°	1,0	157	80 t/m

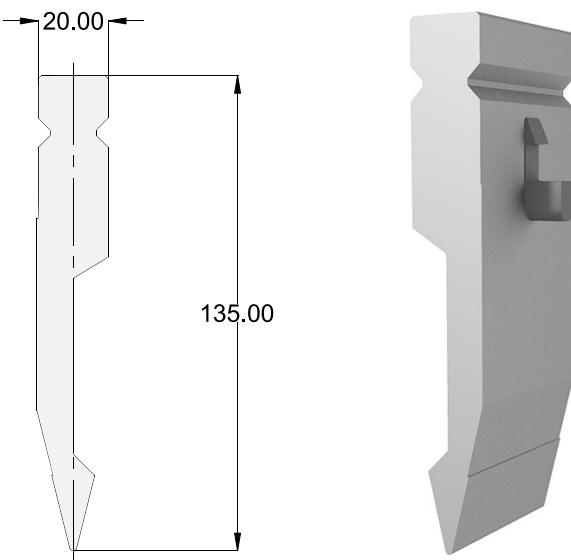
Material 42CrMo4
Buttons available up to 500 mm pieces
Approx. weight 20,0 kg/m



Punch WLNP-013

Angle	Radius	Height	Tonnage
28°	1,0	135	100 t/m

Material 42CrMo4
Buttons available up to 515 mm pieces
Approx. weight 24,0 kg/m





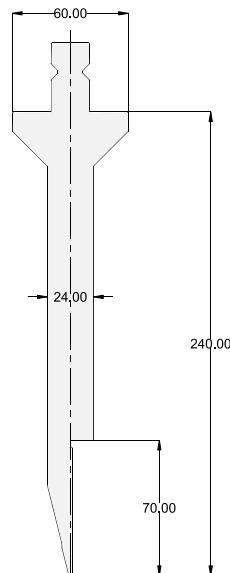
Punch TWGP-013

Angle	Radius	Height	Tonnage
28°	1,0	240	40 t/m

Material 42CrMo4
Buttons available up to 200 mm pieces
Approx. weight 47,6 kg/m

Shoulders loading

Length of pieces available:
25 - 30 - 35 - 40 - 45 - 50 mm
100 hornL - 100 hornR - 100 - 200 - 300 - 500 mm
550 mm standard sectioned set



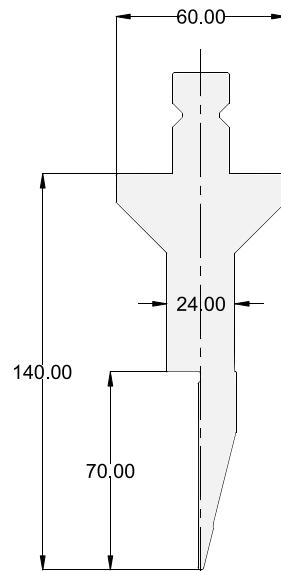
Punch TWGP-017

Angle	Radius	Height	Tonnage
28°	1,0	140	40 t/m

Material 42CrMo4
Buttons available up to 300 mm pieces
Approx. weight 28,8 kg/m

Shoulders loading

Length of pieces available:
25 - 30 - 35 - 40 - 45 - 50 mm
100 hornL - 100 hornR - 100 - 200 - 300 - 500 mm
550 mm standard sectioned set

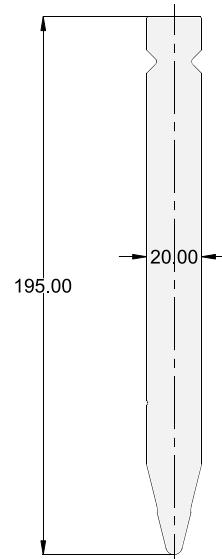


Punch TWGP-016

Angle	Radius	Height	Tonnage
28°	3,0	195	100 t/m

Material 42CrMo4
Buttons available up to 300 mm pieces
Approx. weight 28,2 kg/m

Length of pieces available:
25 - 30 - 35 - 40 - 45 - 50 mm
100 hornL - 100 hornR - 100 - 200 - 300 - 500 mm
550 mm standard sectioned set





Punch TWGP-019

Angle	Radius	Height	Tonnage
26°	0,8	195	100 t/m

Material 42CrMo4

Buttons available up to 500 mm pieces

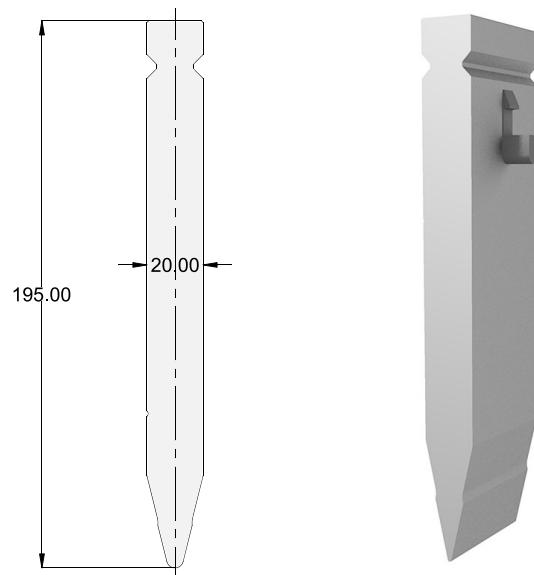
Approx. weight 27,0 kg/m

Length of pieces available:

25 - 30 - 35 - 40 - 45 - 50 mm

100 hornL - 100 hornR - 100 - 200 - 300 - 500 mm

550 mm standard sectioned set





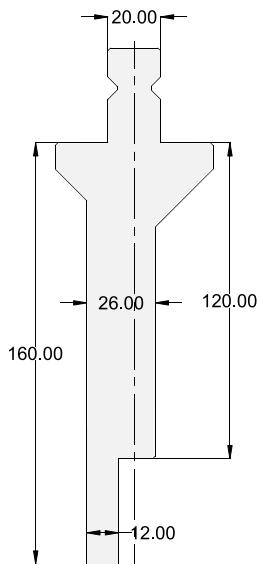
Holder for punch inserts TWRI-001

Use	Height	Tonnage
TWRI-003 punch inserts	120	100 t/m

Material 1.2312 quenched
Buttons available up to 200 mm pieces
Approx. weight 39,2 kg/m

Shoulders loading

Length of pieces available:
100 - 200 - 300 - 500 mm
550 mm standard sectioned set

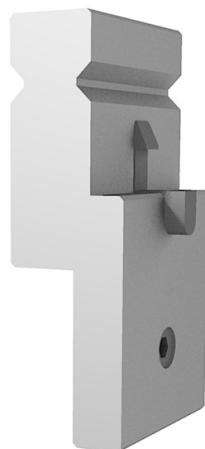
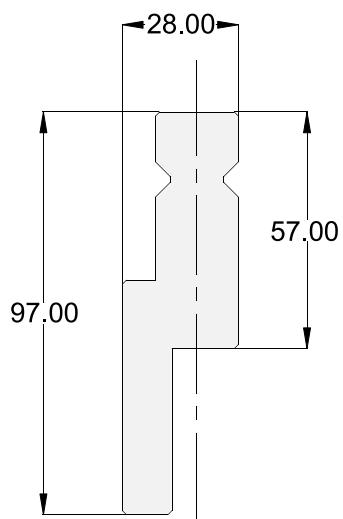


Holder for punch inserts TWRI-002

Use	Height	Tonnage
TWRI-003 punch inserts	97	100 t/m

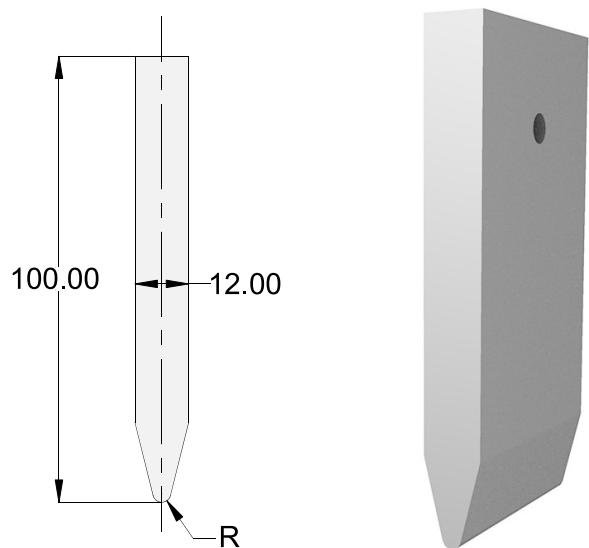
Material 1.2312 quenched
Buttons available up to 500 mm pieces
Approx. weight 13,4 kg/m

Length of pieces available:
100 - 200 - 300 - 500 mm
550 mm standard sectioned set



Punch inserts TWRI-003

Art.	Angle	Radius	Weight
TWRI-003 8610	86°	1,0	9,1 kg/m
TWRI-003 8410	84°	1,0	9,1 kg/m
TWRI-003 2805	28°	0,5	9,0 kg/m
TWRI-003 2810	28°	1,0	9,0 kg/m
TWRI-003 2820	28°	2,0	9,0 kg/m
TWRI-003 2830	28°	3,0	9,1 kg/m
TWRI-003 2840	28°	4,0	9,1 kg/m
TWRI-003 2850	28°	5,0	9,2 kg/m
TWRI-003 2860	28°	6,0	9,2 kg/m

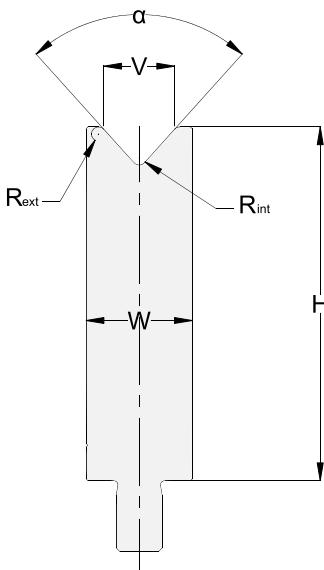


Material 1.2312 quenched

To be used with holders TWRI-001 or TWRI-002

Length of pieces available: 100 - 200 - 300 - 500 mm

550 mm standard sectioned set



Classic dies TW Professional

86°

Code	V (opening)	W (width)	H (height)	R (radius)	Tonnage	Weight
TSD-010 8606	6	20	100	0,6 ^{ext} / 0,6 ^{int}	100 t/m	17,4 kg/m
TSD-010 8608	8	20	100	0,8 ^{ext} / 0,8 ^{int}	100 t/m	17,4 kg/m
TSD-010 8610	10	20	100	1,0 ^{ext} / 1,0 ^{int}	100 t/m	17,4 kg/m
TSD-010 8612	12	25	100	1,0 ^{ext} / 1,0 ^{int}	100 t/m	20,4 kg/m
TSD-010 8616	16	30	100	1,6 ^{ext} / 1,6 ^{int}	100 t/m	25,0 kg/m
TSD-010 8620	20	30	100	2,0 ^{ext} / 2,0 ^{int}	100 t/m	25,0 kg/m
TSD-010 8624	24	35	100	2,5 ^{ext} / 2,5 ^{int}	100 t/m	28,0 kg/m
TSD-010 8630	30	45	100	3,0 ^{ext} / 3,0 ^{int}	100 t/m	35,0 kg/m
TSD-010 8640	40	55	100	3,0 ^{ext} / 3,0 ^{int}	120 t/m	40,0 kg/m
TSD-010 8650	50	75	100	3,0 ^{ext} / 5,0 ^{int}	150 t/m	55,0 kg/m

84°

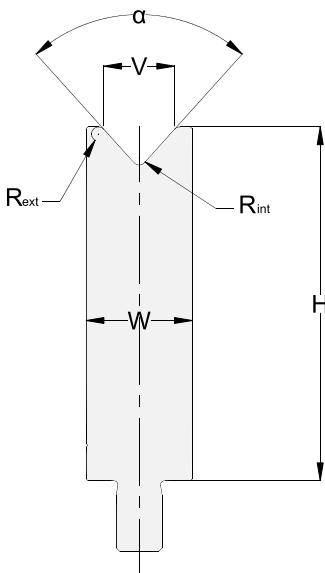
Code	V (opening)	W (width)	H (height)	R (radius)	Tonnage	Weight
TSD-010 8406	6	20	100	0,6 ^{ext} / 0,6 ^{int}	100 t/m	17,4 kg/m
TSD-010 8408	8	20	100	0,8 ^{ext} / 0,8 ^{int}	100 t/m	17,4 kg/m
TSD-010 8410	10	20	100	1,0 ^{ext} / 1,0 ^{int}	100 t/m	17,4 kg/m
TSD-010 8412	12	25	100	1,0 ^{ext} / 1,0 ^{int}	100 t/m	20,4 kg/m
TSD-010 8414	14	20/25	100	1,6 ^{ext} / 1,6 ^{int}	90 t/m	17,6 kg/m
TSD-010 8416	16	30	100	1,6 ^{ext} / 1,6 ^{int}	100 t/m	25,0 kg/m
TSD-010 8420	20	30	100	2,0 ^{ext} / 2,0 ^{int}	100 t/m	25,0 kg/m

Material 42CrMo4

Length of pieces available:

25 - 30 - 35 - 40 - 45 - 50 - 100 - 200 - 300 - 500 mm

550 mm standard sectioned set



Classic dies TW Professional

80°

Code	V (opening)	W (width)	H (height)	R (radius)	Tonnage	Weight
TSD-010 8024	24	35	100	2,5 ^{ext} / 2,5 ^{int}	100 t/m	28,0 kg/m
TSD-010 8030	30	45	100	5,0 ^{ext} / 3,0 ^{int}	120 t/m	35,0 kg/m
TSD-010 8040	40	55	100	5,0 ^{ext} / 3,0 ^{int}	150 t/m	41,2 kg/m
TSD-010 8050	50	65	100	5,0 ^{ext} / 5,0 ^{int}	150 t/m	46,0 kg/m



Material 42CrMo4

Length of pieces available:

25 - 30 - 35 - 40 - 45 - 50 - 100 - 200 - 300 - 500 mm

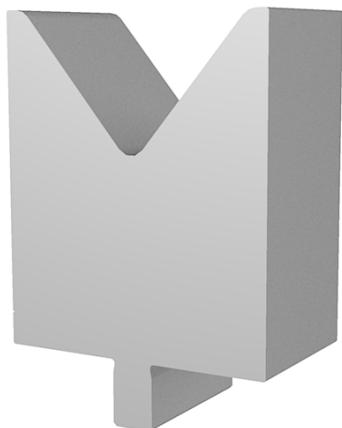
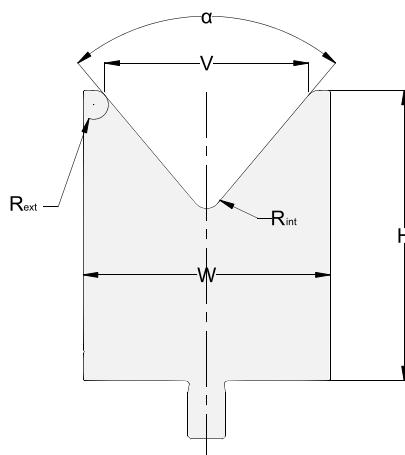
550 mm standard sectioned set

TSD-010 8070, TSD-010 8080

- only up to 300 mm solid

TSD-010 8090, TSD-011 8010, TSD-011 6012

- only up to 200 mm solid



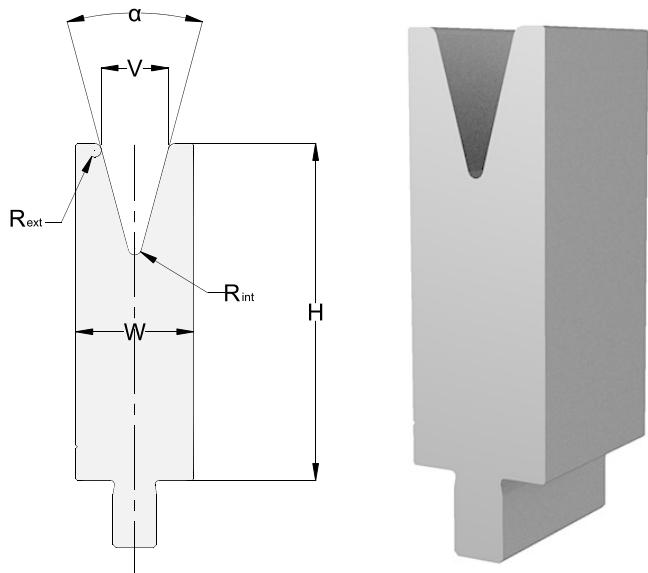
Heavy dies TW Professional

80°

Code	V (opening)	W (width)	H (height)	R (radius)	Tonnage	Weight
TSD-010 8060	60	75	100	5,0 ^{ext} / 5,0 ^{int}	150 t/m	52,0 kg/m
TSD-010 8070	70	85	100	5,0 ^{ext} / 5,0 ^{int}	150 t/m	56,0 kg/m
TSD-010 8080	80	80	100	5,0 ^{ext} / 5,0 ^{int}	150 t/m	64,0 kg/m
TSD-010 8090	90	110	120	8,0 ^{ext} / 5,0 ^{int}	150 t/m	85,0 kg/m
TSD-011 8010	100	120	120	8,0 ^{ext} / 5,0 ^{int}	150 t/m	89,0 kg/m

60°

Code	V (opening)	W (width)	H (height)	R (radius)	Tonnage	Weight
TSD-011 6012	120	145	120	8,0 ^{ext} / 8,0 ^{int}	160 t/m	91,0 kg/m



Classic dies TW Professional

30°

Code	V (opening)	W (width)	H (height)	R (radius)	Tonnage	Weight
TSD-010 3006	6	20	100	0,6 ^{ext} / 0,6 ^{int}	60 t/m	17,4 kg/m
TSD-010 3008	8	20	100	1,0 ^{ext} / 1,0 ^{int}	50 t/m	17,2 kg/m
TSD-010 3010	10	20	100	1,0 ^{ext} / 1,0 ^{int}	50 t/m	17,2 kg/m
TSD-010 3012	12	25	100	1,0 ^{ext} / 1,0 ^{int}	56 t/m	20,4 kg/m
TSD-010 3016	16	30	100	1,6 ^{ext} / 1,6 ^{int}	68 t/m	23,6 kg/m
TSD-010 3020	20	35	100	2,0 ^{ext} / 2,0 ^{int}	50 t/m	26,0 kg/m
TSD-010 3024	24	40	100	2,5 ^{ext} / 2,5 ^{int}	55 t/m	29,0 kg/m
TSD-010 3030	30	55	100	3,0 ^{ext} / 3,0 ^{int}	85 t/m	38,0 kg/m
TSD-010 3040	40	60	100	5,0 ^{ext} / 5,0 ^{int}	73 t/m	37,0 kg/m
TSD-010 3050	50	75	100	5,0 ^{ext} / 5,0 ^{int}	100 t/m	46,0 kg/m

30°R3

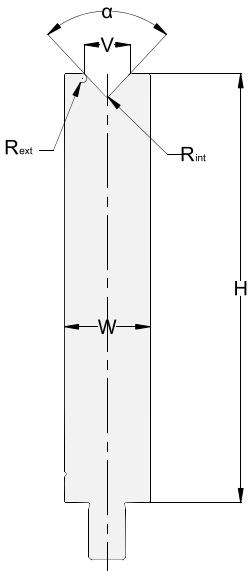
Code	V (opening)	W (width)	H (height)	R (radius)	Tonnage	Weight
TSD-01R 3006	6	20	100	3,0 ^{ext} / 0,6 ^{int}	45 t/m	17,4 kg/m
TSD-01R 3008	8	20	100	3,0 ^{ext} / 1,0 ^{int}	40 t/m	17,2 kg/m
TSD-01R 3010	10	20	100	3,0 ^{ext} / 1,0 ^{int}	30 t/m	17,2 kg/m
TSD-01R 3012	12	25	100	3,0 ^{ext} / 2,0 ^{int}	40 t/m	20,4 kg/m
TSD-01R 3016	16	30	100	3,0 ^{ext} / 1,6 ^{int}	40 t/m	23,6 kg/m

Material 42CrMo4

Length of pieces available:

25 - 30 - 35 - 40 - 45 - 50 - 100 - 200 - 300 - 500 mm

550 mm standard sectioned set



Classic dies TW Economy

86°

Code	V (opening)	W (width)	H (height)	R (radius)	Tonnage	Weight
TSD-005 8606	6	20	150	0,6 ^{ext} / 0,5 ^{int}	100 t/m	26,0 kg/m
TSD-005 8608	8	20	150	0,8 ^{ext} / 0,5 ^{int}	100 t/m	26,0 kg/m
TSD-005 8610	10	20	150	1,0 ^{ext} / 0,5 ^{int}	100 t/m	26,0 kg/m
TSD-005 8612	12	25	150	1,0 ^{ext} / 0,5 ^{int}	100 t/m	32,0 kg/m
TSD-005 8616	16	30	150	1,6 ^{ext} / 0,5 ^{int}	100 t/m	36,0 kg/m
TSD-005 8620	20	30	150	2,0 ^{ext} / 0,5 ^{int}	100 t/m	36,0 kg/m
TSD-005 8624	24	35	150	2,5 ^{ext} / 0,5 ^{int}	100 t/m	36,0 kg/m

30°

Code	V (opening)	W (width)	H (height)	R (radius)	Tonnage	Weight
TSD-005 3006	6	20	150	0,6 ^{ext} / 1,0 ^{int}	50 t/m	26,0 kg/m
TSD-005 3008	8	20	150	1,0 ^{ext} / P2*	40 t/m	26,0 kg/m
TSD-005 3010	10	20	150	1,0 ^{ext} / P2*	40 t/m	26,0 kg/m
TSD-005 3012	12	25	150	1,0 ^{ext} / P2*	50 t/m	30,0 kg/m
TSD-005 3016	16	30	150	1,6 ^{ext} / P5*	45 t/m	36,0 kg/m
TSD-005 3020	20	35	150	2,0 ^{ext} / P5*	50 t/m	40,0 kg/m
TSD-005 3024	24	40	150	2,5 ^{ext} / P5*	50 t/m	44,0 kg/m

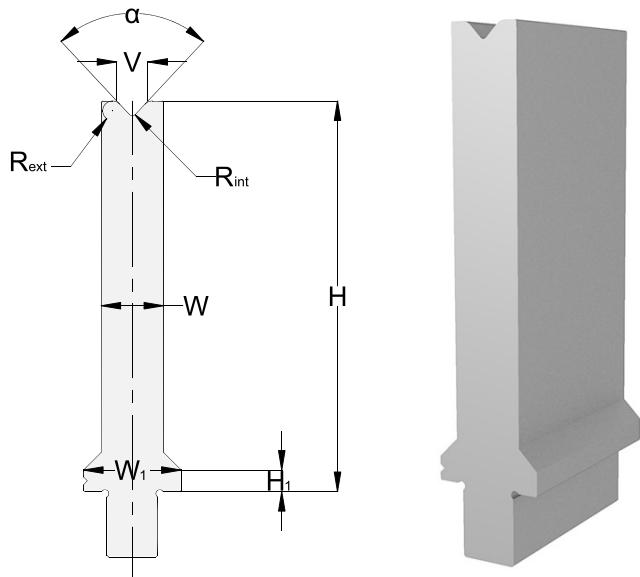
Material C45

Length of pieces available:

25 - 30 - 35 - 40 - 45 - 50 - 100 - 200 - 300 - 500 mm

550 mm standard sectioned set

* P means flat part (no radius)



Classic dies WLT Professional

86°

Code	V (opening)	W (width)	H (height)	R (radius)	Tonnage	Weight
TSD-015 8606	6	16 / W ₁ 25	100 / H ₁ 5,5	2,0 ^{ext} / 0,8 ^{int}	120 t/m	15,0 kg/m
TSD-015 8608	8	16 / W ₁ 25	100 / H ₁ 5,5	2,5 ^{ext} / 1,0 ^{int}	120 t/m	15,0 kg/m
TSD-015 8610	10	20 / W ₁ 25	100 / H ₁ 7,5	2,5 ^{ext} / 1,2 ^{int}	120 t/m	18,0 kg/m
TSD-015 8612	12	20 / W ₁ 25	100 / H ₁ 7,5	3,0 ^{ext} / 1,2 ^{int}	120 t/m	18,0 kg/m
TSD-015 8616	16	25	100	3,5 ^{ext} / 1,2 ^{int}	120 t/m	21,0 kg/m
TSD-015 8620	20	30	100	4,0 ^{ext} / 1,2 ^{int}	120 t/m	24,0 kg/m

80°

Code	V (opening)	W (width)	H (height)	R (radius)	Tonnage	Weight
TSD-015 8024	24	35	100	5,0 ^{ext} / 1,2 ^{int}	125 t/m	28,0 kg/m

30°

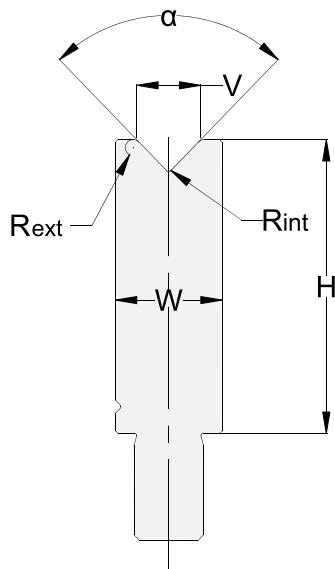
Code	V (opening)	W (width)	H (height)	R (radius)	Tonnage	Weight
TSD-015 3006	6	16 / W ₁ 25	100 / H ₁ 5,5	2,0 ^{ext} / 1,0 ^{int}	40 t/m	14,5 kg/m
TSD-015 3008	8	16 / W ₁ 25	100 / H ₁ 5,5	2,5 ^{ext} / 1,0 ^{int}	35 t/m	14,0 kg/m
TSD-015 3010	10	20 / W ₁ 25	100 / H ₁ 7,5	2,5 ^{ext} / 1,6 ^{int}	55 t/m	17,0 kg/m
TSD-015 3012	12	20 / W ₁ 25	100 / H ₁ 7,5	3,0 ^{ext} / 1,2 ^{int}	40 t/m	16,5 kg/m
TSD-015 3016	16	30	100	3,5 ^{ext} / 1,2 ^{int}	60 t/m	23,5 kg/m
TSD-015 3020	20	35	100	4,0 ^{ext} / 2,0 ^{int}	55 t/m	26,5 kg/m
TSD-015 3024	24	40	100	5,0 ^{ext} / 4,0 ^{int}	45 t/m	29,0 kg/m

Material 42CrMo4

Length of pieces available:

100 - 200 - 515 mm

550 mm WLT sectioned set



Classic dies BST Economy

88°

Code	V (opening)	W (width)	H (height)	R (radius)	Tonnage	Weight
BST-005 8806	6	15/20	55	0,4 ^{ext} / 0,5 ^{int}	100 t/m	8,7 kg/m
BST-005 8808	8	15/20	55	0,5 ^{ext} / 0,5 ^{int}	100 t/m	8,7 kg/m
BST-005 8810	10	20	55	1,0 ^{ext} / 0,5 ^{int}	100 t/m	10,4 kg/m
BST-005 8812	12	20	55	1,5 ^{ext} / 0,5 ^{int}	100 t/m	10,3 kg/m
BST-005 8816	16	30	55	2,0 ^{ext} / 0,5 ^{int}	100 t/m	14,4 kg/m
BST-005 8820	20	30	55	2,0 ^{ext} / 0,5 ^{int}	100 t/m	14,1 kg/m
BST-005 8824	24	40	55	3,0 ^{ext} / 0,5 ^{int}	100 t/m	18,1 kg/m

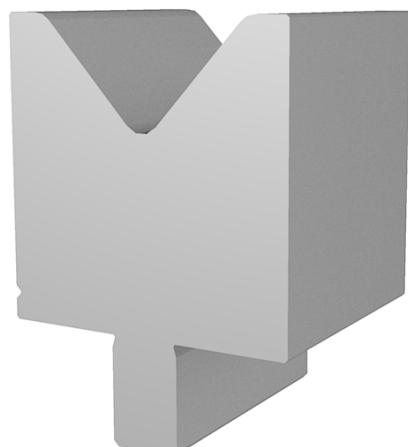
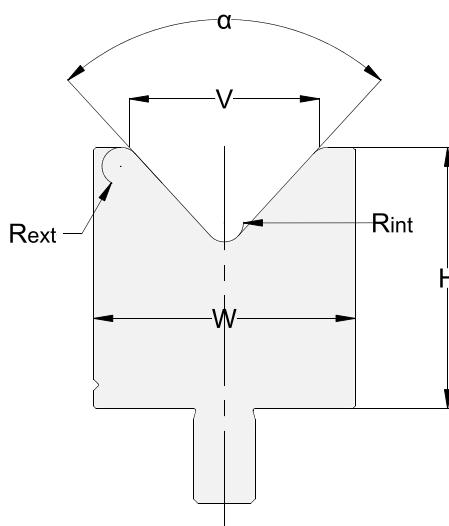
▲
Material C45

Length of pieces available:

100 - 500 - 1000 mm

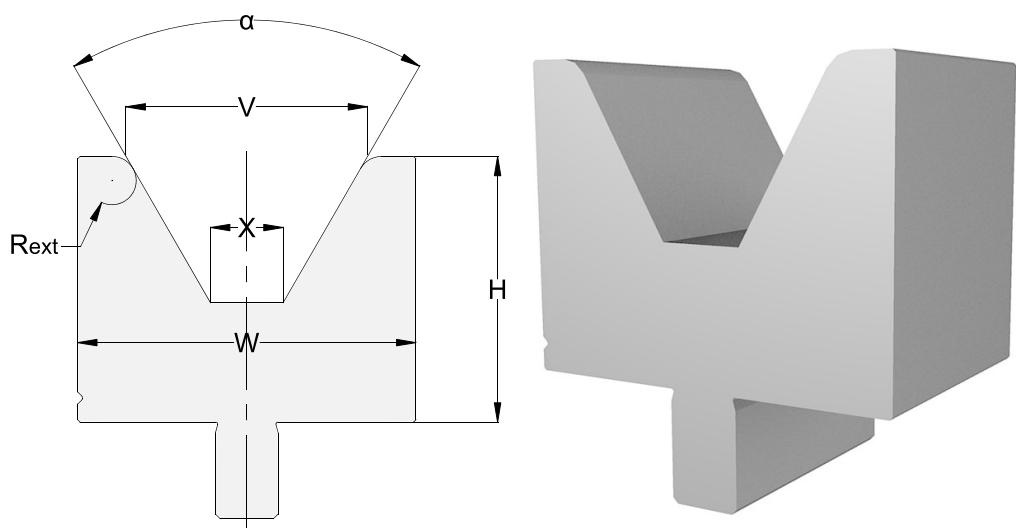
550 mm - 1100 mm BST-type sectioned set

▼



85°

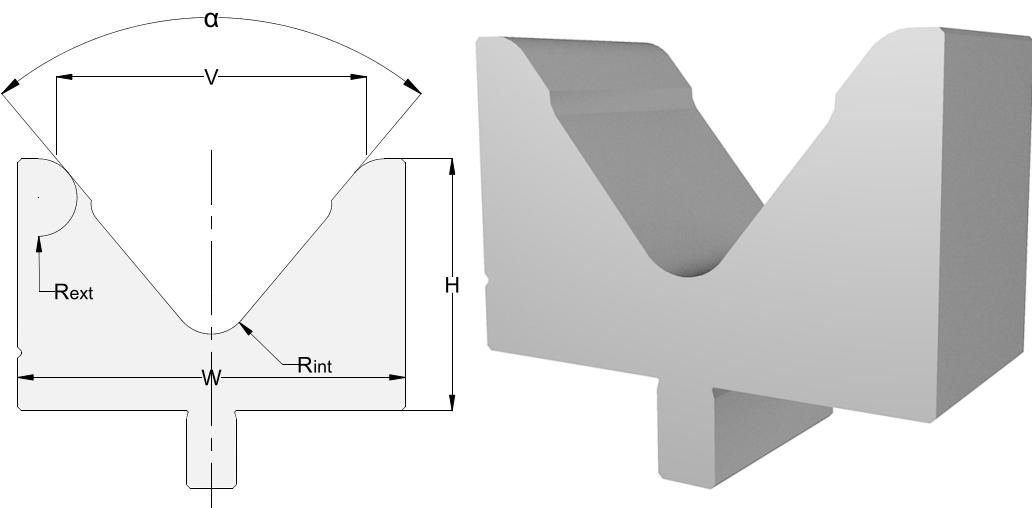
Code	V (opening)	W (width)	H (height)	R (radius)	Tonnage	Weight
BST-005 8532	32	50	55	4,0 ^{ext} / 3,0 ^{int}	100 t/m	21,4 kg/m
BST-005 8540	40	55	55	4,0 ^{ext} / 4,0 ^{int}	100 t/m	22,3 kg/m



Classic dies BST Economy

60°

Code	V (opening)	W (width)	H (height)	R (radius)	Tonnage	Weight
BST-005 6040	40	55	55	5,0 ^{ext} / 5,0 ^{int}	100 t/m	20,4 kg/m
BST-005 6050	50	70	55	5,0 ^{ext} / X=15	100 t/m	24,4 kg/m
BST-005 6060	60	80	55	7,0 ^{ext} / X=15	100 t/m	31,2 kg/m



Heavy dies BST Economy

80°

Code	V (opening)	W (width)	H (height)	R (radius)	Tonnage	Weight
BST-005 8080	80	100	65	10,0 ^{ext} / 10,0 ^{int}	100 t/m	67,0 kg/m
BST-005 8010	100	125	85	12,0 ^{ext} / 16,0 ^{int}	100 t/m	51,0 kg/m
BST-005 8012	120	120	105	15,0 ^{ext} / 20,0 ^{int}	100 t/m	73,0 kg/m

Material C45

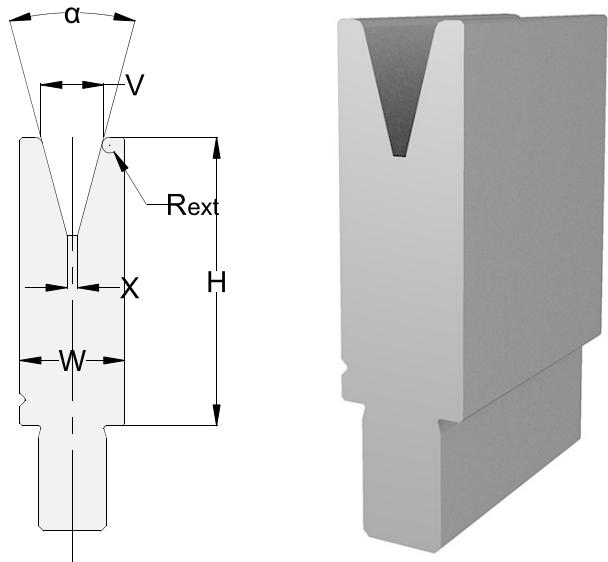
Length of pieces available:

100 - 500 - 1000 mm

500 mm solid only for BST 005-8010, BST-005 8012

550 mm - 1100 mm BST-type sectioned set

1100 mm BST-type sectioned set only for
BST-005 8080, BST-005 8010, BST-005 8012



Classic dies BST Economy

30°

Code	V (opening)	W (width)	H (height)	R (radius)	Tonnage	Weight
BST-005 3006	6	15/20	55	0,6 ^{ext} / 1,0 ^{int}	35 t/m	8,6 kg/m
BST-005 3008	8	15/20	55	0,8 ^{ext} / X=2	40 t/m	8,4 kg/m
BST-005 3010	10	20	55	1,0 ^{ext} / X=2	50 t/m	9,9 kg/m
BST-005 3012	12	20	55	1,5 ^{ext} / X=2	40 t/m	9,6 kg/m
BST-005 3016	16	30	55	2,0 ^{ext} / X=5	50 t/m	13,2 kg/m
BST-005 3020	20	35	55	2,5 ^{ext} / X=5	55 t/m	14,3 kg/m
BST-005 3024	24	40	55	3,0 ^{ext} / X=8	65 t/m	15,5 kg/m
BST-005 3032	32	60	60	4,0 ^{ext} / X=10	65 t/m	23,4 kg/m

Material C45

Length of pieces available:

100 - 500 - 1000 mm

550 mm - 1100 mm BST-type sectioned set



Holder for radius inserts TWRP-R01

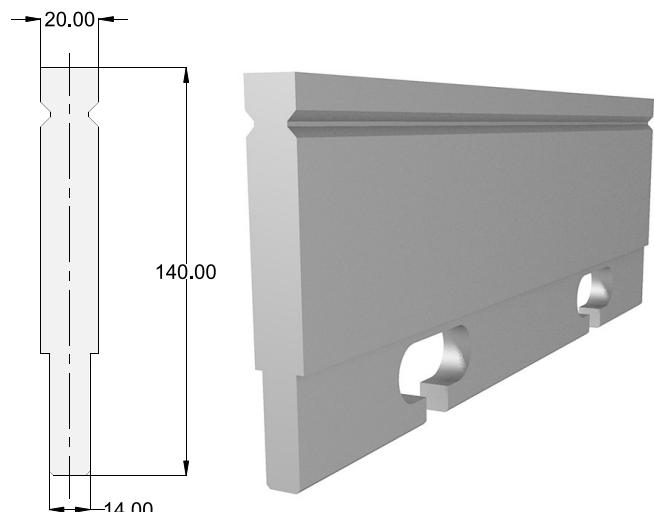
Use	Height	Tonnage
PRI- inserts	140	100 t/m

Material C45
Buttons available for 410 mm pieces (*option)
Approx. weight 18,7 kg/m

Length of pieces available:

410 - 830 mm

Section sets are not available



Adapter for small inserts PRI-009

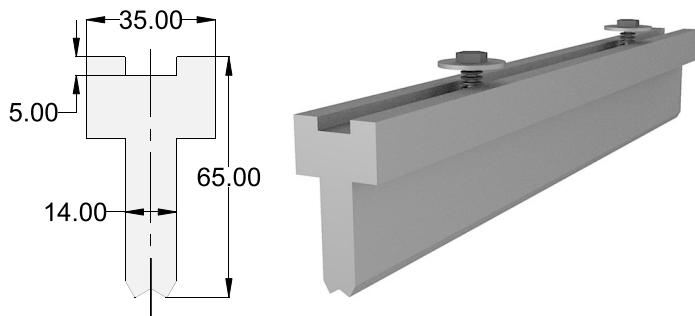
Art.	Radius	Height	Tonnage
PRI-009 RS	R3-R4,5	65	50 t/m
PRI-009 RM	R5-R6,5	65	50 t/m

Material C45
Approx. weight 9,9 kg/m To be used with holder TWRP-R01
Adapter to be used only for small inserts R6,5 or smaller

Length of pieces available:

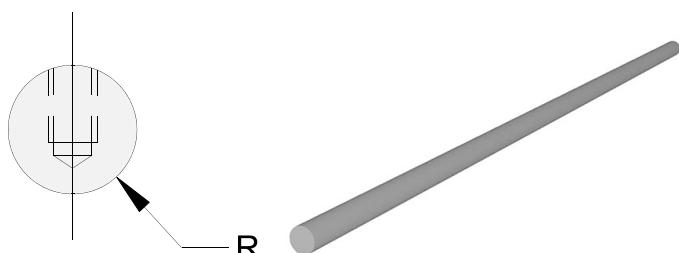
410 - 830 mm

Section sets are not available



Radius inserts PRI-010

Art.	Radius	Weight
PRI-010 011	3,0	0,3 kg/m
PRI-010 01B	3,5	0,4 kg/m
PRI-010 012	4,0	0,4 kg/m
PRI-010 013	4,5	0,5 kg/m
PRI-010 014	5,0	0,6 kg/m
PRI-010 015	5,5	0,7 kg/m
PRI-010 016	6,0	0,9 kg/m
PRI-010 017	6,5	1,1 kg/m



Material C45

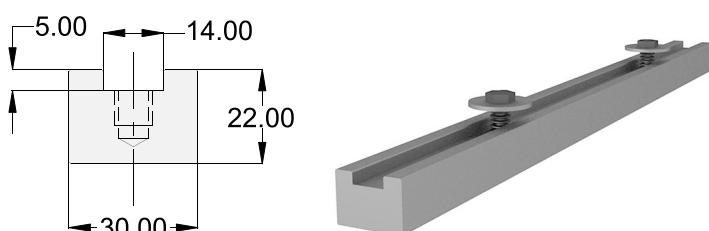
To be used with adapters PRI-009

Length of pieces available: 415 - 835 mm Section sets are not available

Flattening insert PRI-014

Material C45
Approx. weight 4,6 kg/m To be used with holder TWRP-R01

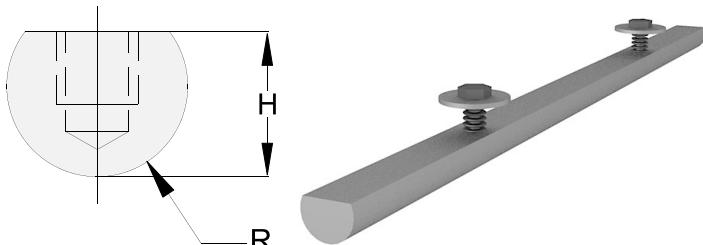
Length of pieces available: 415 - 835 mm Section sets are not available





Radius inserts PRI-011

Art.	Radius	Height	Weight
PRI-011 070	7,0	11,5	1,1 kg/m
PRI-011 075	7,5	11,5	1,1 kg/m
PRI-011 080	8,0	13,0	1,3 kg/m
PRI-011 090	9,0	16,0	1,9 kg/m
PRI-011 100	10,0	16,0	2,1 kg/m
PRI-011 110	11,0	16,0	2,3 kg/m
PRI-011 115	11,5	16,0	2,4 kg/m
PRI-011 120	12,0	20,0	3,1 kg/m



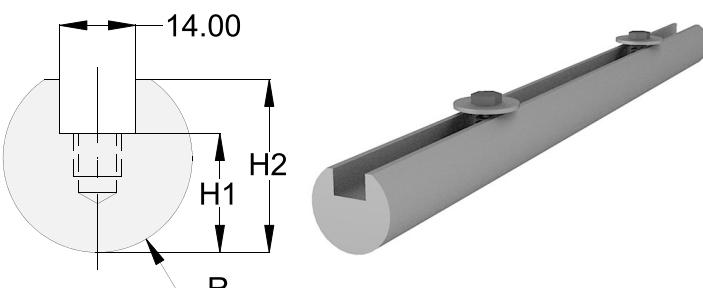
Material C45 To be used with holder TWRP-R01

Length of pieces available:

415 - 835 mm Section sets are not available

Radius inserts PRI-012

Art.	Radius	H1	H2	Weight
PRI-012 125	12,5	21,0	16,0	2,9 kg/m
PRI-012 130	13,0	23,0	17,0	3,3 kg/m
PRI-012 140	14,0	25,0	19,0	3,8 kg/m
PRI-012 150	15,0	27,0	20,0	4,5 kg/m
PRI-012 160	16,0	28,0	21,0	5,1 kg/m
PRI-012 170	17,0	31,5	21,5	5,8 kg/m
PRI-012 175	17,5	32,0	22,0	6,1 kg/m
PRI-012 190	19,0	32,0	25,0	7,2 kg/m
PRI-012 200	20,0	34,0	24,0	7,8 kg/m



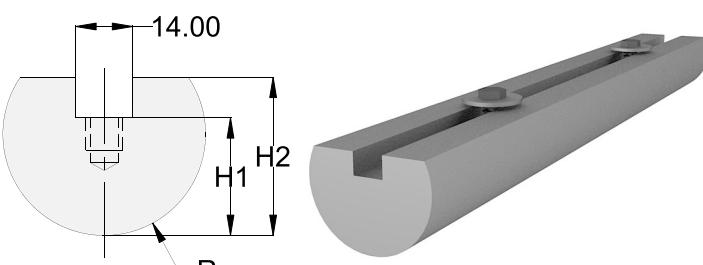
Material C45 To be used with holder TWRP-R01

Length of pieces available: 415 - 835 mm

Section sets are not available

Radius inserts PRI-013

Art.	Radius	H1	H2	Weight
PRI-013 225	22,5	33,0	25,0	8,9 kg/m
PRI-013 250	25,0	39,0	29,0	11,8 kg/m
PRI-013 275	27,5	44,0	34,0	14,9 kg/m
PRI-013 300	30,0	44,0	34,0	16,3 kg/m
PRI-013 350	35,0	55,0	45,0	24,3 kg/m
PRI-012 400	40,0	55,0	45,0	27,8 kg/m
PRI-012 450	45,0	60,0	50,0	34,2 kg/m
PRI-012 500	50,0	64,0	53,0	40,5 kg/m



Material C45 To be used with holder TWRP-R01

Length of pieces available: 415 - 835 mm

Section sets are not available



Flattening punch TWFT-001

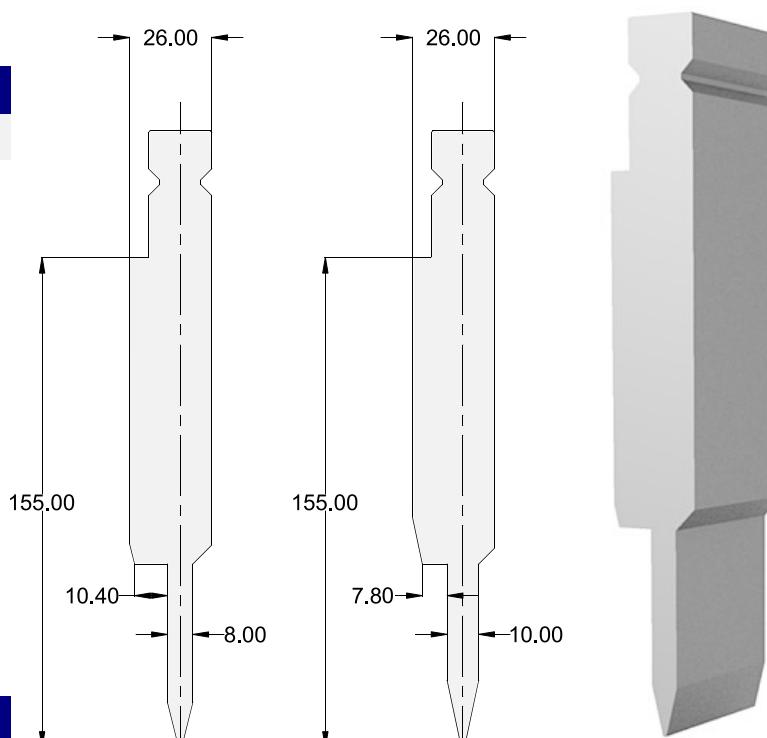
Art.	Angle	R	H	Tonnage	Weight
TWFT-001 2806	28°	0,6	155	80 t/m	28,6 kg/m
TWFT-001 2406	24°	0,6	155	50 t/m	29,2 kg/m

Material C45 tempered
With pins only; buttons only by request

* TWFT-001 2806 - max. 1,2 mm thickness
* TWFT-001 2406 - max. 1,5 mm thickness

Length of pieces available:

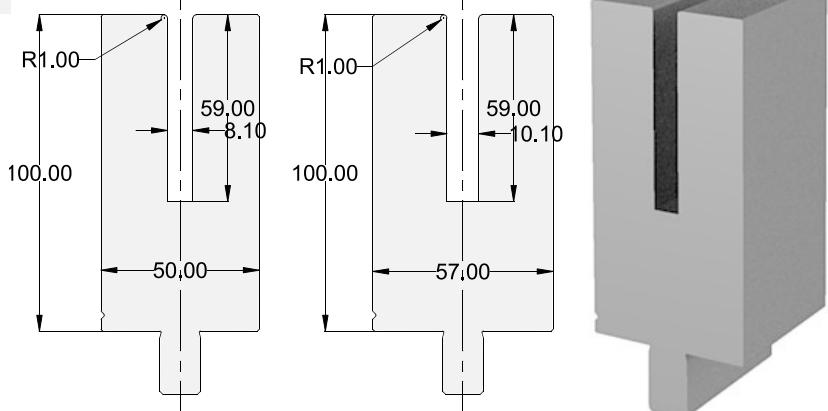
500 mm
550 mm standard sectioned set



Flattening die TWFT-002

Art.	U-opening	H	Tonnage	Weight
TWFT-002 U812	8,10	100	50 t/m	37,4 kg/m
TWFT-002 U105	10,10	100	50 t/m	42,0 kg/m

Material C45 tempered



Length of pieces available:

500 mm

550 mm standard sectioned set

Flattening springed die TWFT-003 26°

Art.	V-opening	R	H	Tonnage	Weight
TWFT-003 2610	10	1,5	135	100 t/m	49,2 kg/m
TWFT-003 2612	12	3,0	135	100 t/m	48,7 kg/m

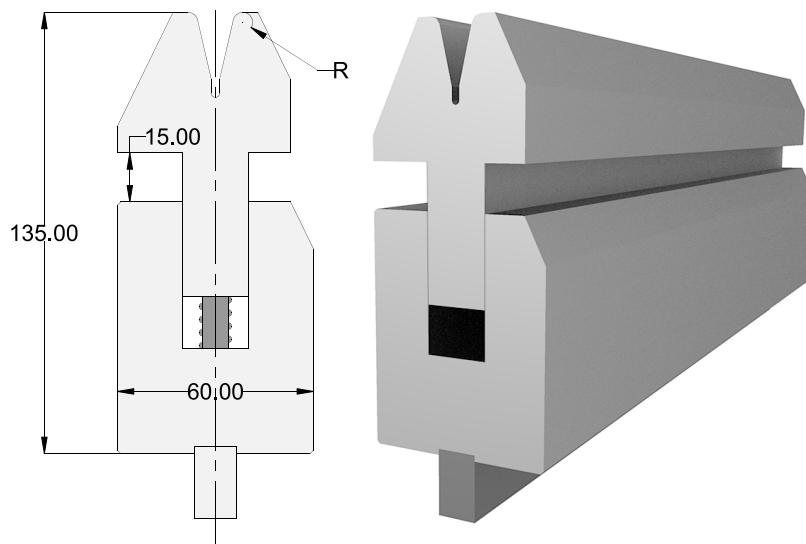
Material C45 tempered

For proper use - to use only with punch 26° (TWGP-019)

* TWFT-003 2610 - 1,5-2,5 mm thickness
* TWFT-003 2612 - 1,5-3,0 mm thickness

Length of pieces available:

415 - 835 mm





Flattening addon TWFT-004

Angle	W	Height	Tonnage
30°	28,90	100	40 t/m

Material C45

To use with 30° H=100 dies (codes TSD-010 with holes)

Approx. weight 26,0 kg/m

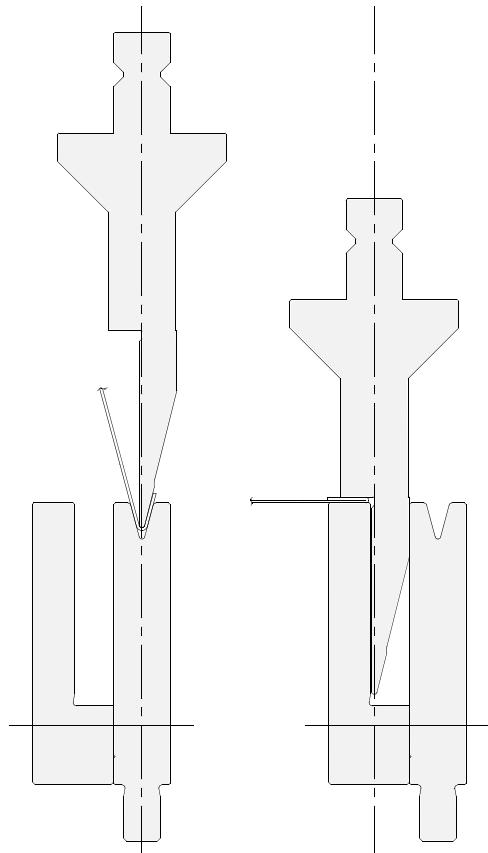
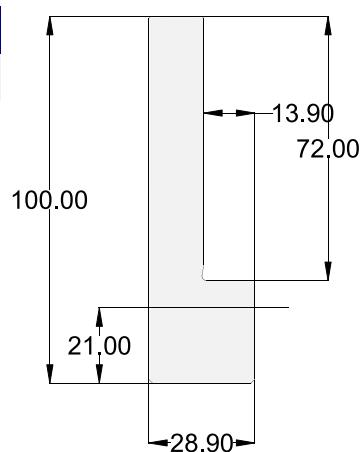
Flattening with lower tool displacement

To use with punches TWGP-013 / TWGP-017 only

Length of pieces available:

25 - 30 - 35 - 40 - 45 - 50 - 100 - 200 - 300 - 500 mm

550 mm standard sectioned set





Holder for Z-inserts TWZP-001

Use	Height	Tonnage
PZI-inserts	123 / 88	80 t/m

Material C45
Only with pins
Approx. weight 59,9 kg/m (for set upper + lower)

Length of pieces available:

415 - 835 mm

Section sets are not available

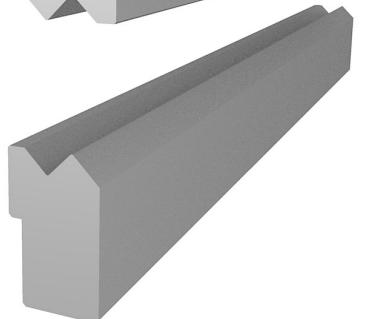
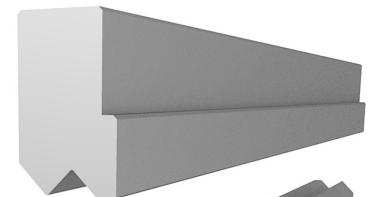
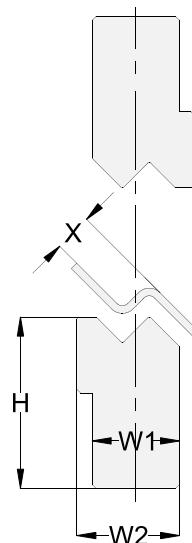
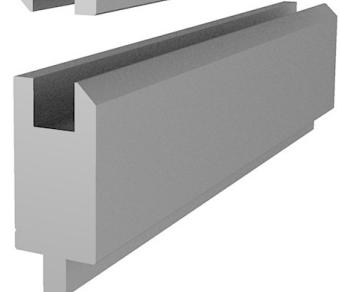
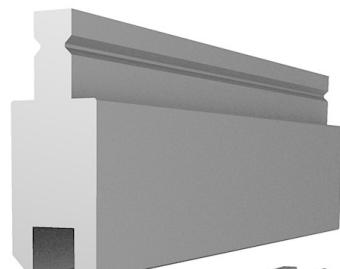
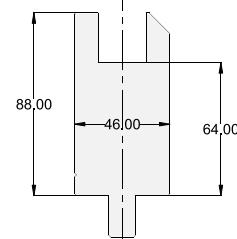
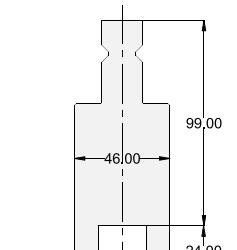
Z-shape inserts PZI-001

Art.	Angle	H	W1	W2	X	Weight	Max.thickness
PZI-001 1610	160°	36	23	23	1,0	12,0 kg/m	0,5 mm
PZI-001 1615	160°	36	23	23	1,5	12,0 kg/m	0,6 mm
PZI-001 1520	150°	36	23	23	2,0	12,0 kg/m	0,8 mm
PZI-001 1425	140°	36	23	23	2,5	12,0 kg/m	1,0 mm
PZI-001 9001	90°	36	23	23	1,0	12,0 kg/m	0,5 mm
PZI-001 9015	90°	36	23	23	1,5	12,0 kg/m	0,6 mm
PZI-001 9020	90°	36	23	23	2,0	12,0 kg/m	0,8 mm
PZI-001 9025	90°	36	23	23	2,5	12,0 kg/m	1,0 mm
PZI-001 9030	90°	36	23	23	3,0	12,0 kg/m	1,0 mm
PZI-001 9035	90°	36	23	23	3,5	12,0 kg/m	1,2 mm
PZI-001 9040	90°	36	23	23	4,0	12,0 kg/m	1,2 mm
PZI-001 9045	90°	36	23	23	4,5	12,0 kg/m	1,5 mm
PZI-001 9050	90°	36	23	23	5,0	12,0 kg/m	1,5 mm
PZI-001 9055	90°	36	23	23	5,5	12,0 kg/m	1,5 mm
PZI-001 9060	90°	36	23	23	6,0	12,0 kg/m	1,5 mm
PZI-001 9065	90°	36	23	23	6,5	12,0 kg/m	1,5 mm
PZI-001 9070	90°	36	23	23	7,0	12,0 kg/m	2,0 mm
PZI-001 9075	90°	36	23	23	7,5	12,0 kg/m	2,0 mm
PZI-001 9080	90°	36	23	23	8,0	12,0 kg/m	2,5 mm
PZI-001 9090	90°	45	23	27	9,0	16,2 kg/m	2,5 mm
PZI-001 9010	90°	45	23	27	10,0	16,2 kg/m	3,0 mm
PZI-001 9011	90°	45	23	27	11,0	16,2 kg/m	3,0 mm
PZI-001 9012	90°	45	23	27	12,0	16,2 kg/m	3,0 mm
PZI-001 9013	90°	45	23	32	13,0	17,4 kg/m	3,0 mm
PZI-001 9014	90°	45	23	32	14,0	17,4 kg/m	3,0 mm
PZI-001 9016	90°	45	23	32	15,0	17,4 kg/m	3,0 mm

Material C45

To be used with holder TWZP-001

Length of pieces available: 415 - 835 mm Section sets are not available

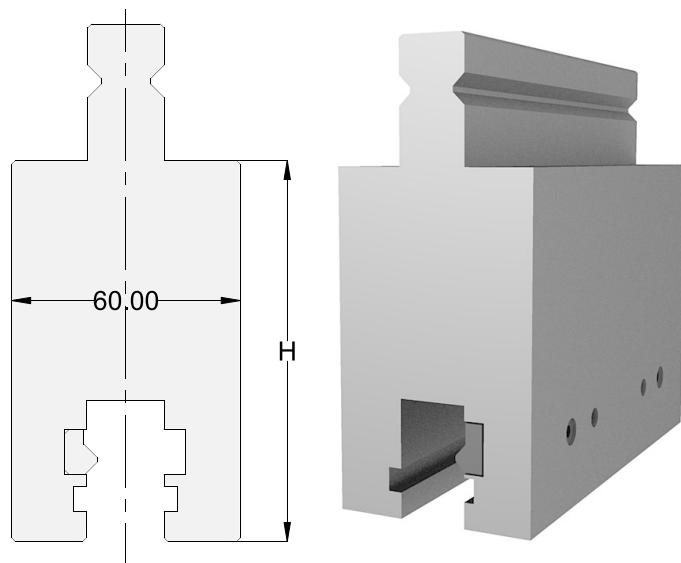




Elongation adapter ATW-001

Art.	W	H	Length	Tonnage	Weight
ATW-001 H100	60	100	150	100 t/m	7 kg
ATW-001 H150	60	150	150	100 t/m	10,4 kg
ATW-001 H200	60	200	150	100 t/m	13,6 kg

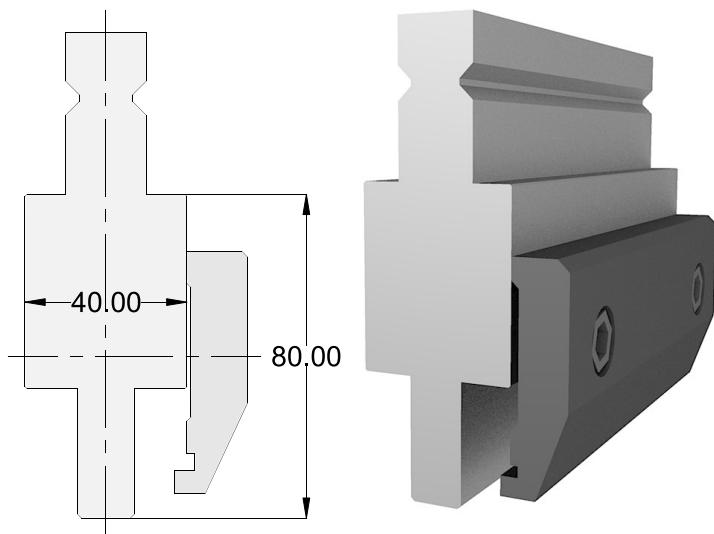
Material C45
Only with pins



Adapter TWPR-001

W	Length	Height	Tonnage
40	150	80	100 t/m

Material C45
Only with pins
Approx. weight 4,4 kg / piece
Adapter from TW System to PRC-EUR System
(upper tooling - punches)
Complete with clamp plate

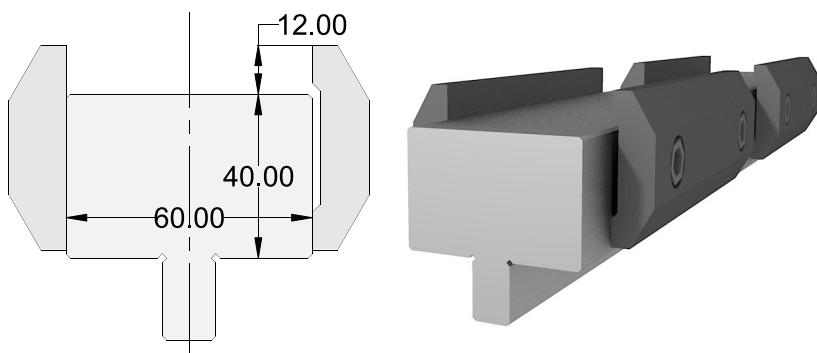


Adapter TWPR-002

W	Height	Tonnage
40	40	100 t/m

Material C45
Approx. weight 25,50 kg/m
Adapter from TW System to PRC-EUR System
(lower tooling - dies)

Length of pieces available:
415 - 835 mm





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PRECITOOLS
PRESS BRAKE TOOLS

Via B. Crespi, 19, MAC 4 – 4°Piano
20159, Milano (MI), Italy
Tel. +39 02 8718 6537
www.press-brake-tools.com
req@press-brake-tools.com

 +39 351 680 0230